

Applications

This flux cored wire primarily intended for as welded applications. It can also be used long for long term stress relieved applications for welding of low alloy high strength steels in particular 1% nickel steels. Recommended for pressure vessels or fabrication of thicker section which require subzero impact properties.

Characteristics on Usage

It is low hydrogen type flux cored wire with highly basic slag having stable & smooth arc, good slag detachability. Weld metal is of radiographic quality. It is used for flat & horizontal position welding with CO₂ shielding.

Welding Positions

1G 2F

Recommended Stick Out

15-20 mm

Shielding Gas

Carbon Dioxide (CO₂) shielding
Gas Flow :20-25 Lit / Min

Chemical Composition Of Weld Metal

| Element | C% | Mn% | Si% | S% | P% | Ni % | Mo % |
|----------------|----------|-----------|----------|-----------|-----------|-----------|-----------|
| Typical Values | 0.045 | 1.00 | 0.50 | 0.010 | 0.015 | 1.00 | 0.45 |
| Spec. reqd. | 0.15 Max | 0.80-1.40 | 0.80 Max | 0.030 Max | 0.030 Max | 0.80-1.10 | 0.20-0.65 |

Mechanical Properties Of Weld Metal

| Property | U.T.S. (N/mm ²) | Y.S. (N/mm ²) | ELONGATION (L = 4d) % | IMPACT (CVN) AT -40 °C (J) |
|----------------|--------------------------------|------------------------------|----------------------------|---------------------------------|
| Typical Values | 620 | 530 | 23 | 50 |
| Spec. reqd. | 550-690 | 470 Min | 19 Min | 27 Min |

Welding Parameters (DC + VE)

| Diameter (mm) | Flat & Horizontal | |
|------------------|-------------------|-------|
| | (A) | (V) |
| 1.20 | 180-210 | 26-30 |
| 1.60 | 210-250 | 26-30 |

Packing

15 kgs. vacuum packed plastic spool.