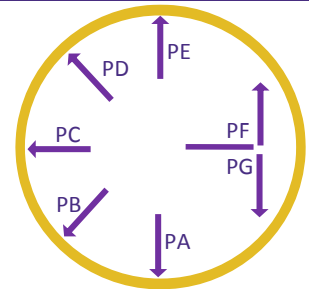


Applications

- Shipbuilding
- Offshore Structure and Pressure vessels
- Structural fabrication

Features

- Low temperature service steel.
- Designed for welding with 100% CO₂ shielding gas.
- Smooth and stable arc with a fast freezing slag.



Typical Chemical Properties of All-Weld Metal (%)

| C | Mn | Si | Cr | Ni | Mo | P | S | V |
|-------|------|-------|------|------|------|------|-------|------|
| 0.043 | 1.20 | 0.035 | 0.03 | 0.48 | 0.04 | 0.04 | 0.012 | 0.01 |

Typical Mechanical Properties of All-Weld Metal

| YS (Mpa) | TS (Mpa) | EL(%) | Temp °C | Impact (J) |
|----------|----------|-------|---------|------------|
| 510 | 590 | 32 | -40 | 86 |

Sizes Available and Recommended Parameter

| Dia/mm | 1.2mm | 1.4mm | 1.6mm |
|-----------------|-----------|-----------|-----------|
| Volt | 23 - 34 | 24 - 42 | 25 - 46 |
| Amp | 150 - 320 | 170 - 400 | 200 - 450 |
| Stick-Out(mm) | 15 - 20 | 15 - 20 | 18 - 25 |
| Gas Flow(l/min) | 20 - 25 | 20 - 25 | 15 - 25 |

Current

DC +

Shielding Gas

100% CO₂

Notes on Usage

- The voltage should be turned up to 1-2V in condition of cable wires with over 15m.
- It's necessary to cover the flux cored wire by canvas if it needs on wire feeder for one night.