

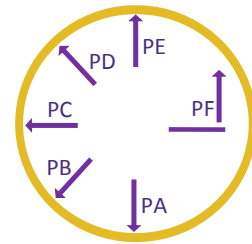
Applications

- Petrochemical industry.
- Pressure vessel and heat exchanger.

Features

- Stable arc and low spatter level.
- It can provide not only excellent crack resistance and high ductility.
- Easy to slag remove.

Welding Position



Typical Chemical Properties of All-Weld Metal (%)

C	Mn	Si	Cr	Ni	Mo	P	S
0.055	1.01	0.37	1.19	-	0.57	0.012	0.009

Typical Mechanical Properties of All-Weld Metal

YS (Mpa)	TS (Mpa)	EL(%)	Temp °C	Impact (J)
545	625	23	-30	90

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

- Keeping the stickout is around 15-20mm.
- Preheating and interpass temperature at 175± 15°C before welding, keeping homologous interlayer-temp.
- Cooling slowly after welding or dehydrogenation treating and releasing stress by PWHT690 ± 15°C.