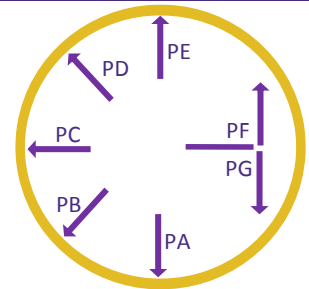


Applications

- Storage Tanks and construction machinery.
- Shipbuilding and offshore drilling rigs.

Features

- Good impact value at low temperature.
- Smooth and stable arc with a fast freezing slag.
- Low hydrogen level (H4).



Typical Chemical Properties of All-Weld Metal (%)

| C | Mn | Si | Cr | Ni | Mo | P | S | Al |
|-------|------|------|------|------|------|------|-------|------|
| 0.040 | 1.22 | 0.45 | 0.03 | 1.59 | 0.05 | 0.02 | 0.015 | 0.03 |

Typical Mechanical Properties of All-Weld Metal

| YS (Mpa) | TS (Mpa) | EL(%) | Temp °C | Impact (J) |
|----------|----------|-------|---------|------------|
| 575 | 637 | 26 | -60 | 70 |

Sizes Available and Recommended Parameter

| Dia/mm | 1.2mm | 1.4mm | 1.6mm |
|-----------------|-----------|-----------|-----------|
| Volt | 25 - 32 | 24 - 36 | 25 - 40 |
| Amp | 150 - 300 | 170 - 360 | 200 - 400 |
| Stick-Out(mm) | 15 - 25 | 15 - 25 | 15 - 25 |
| Gas Flow(l/min) | 20 - 25 | 20 - 25 | 20 - 25 |

Current

DC +

Shielding Gas

100% CO₂

Notes on Usage

- Preheating the base metal at 150 ± 15°C.
- The product cannot use mixed gas, the flow is 20-25L/min.
- Control small heat input quantity and keep lower interlayer temperature, or it is easy make low temperature impact ductility down.
- It's necessary to cover the flux cored wire by canvas if it needs on wire feeder for one night.