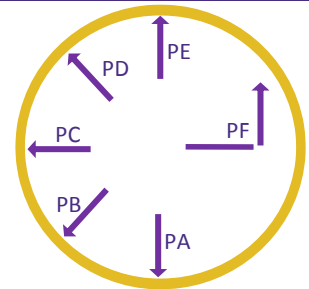


Applications

- Petrochemical industry.
- Pressure vessel and Pressure pipes
- High temperature equipment of chemical synthesis plants.

Features

- Stable arc and low spatter level.



Typical Chemical Properties of All-Weld Metal (%)

C	Mn	Si	Cr	V	Mo	P	S
0.055	0.63	0.32	2.20	0.02	1.0	0.001	0.005

Typical Mechanical Properties of All-Weld Metal

YS (Mpa)	TS (Mpa)	EL(%)	Temp °C	PWHT
643	730	20		690±15°C x1Hr

Sizes Available and Recommended Parameter

Dia/mm	1.2mm
Volt	24 - 35
Amp	160 - 320
Stick-Out(mm)	15 - 20
Gas Flow(l/min)	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.
- Post Weld Heat Treatment (PWHT): 690 + 15°C x 1h as required.