

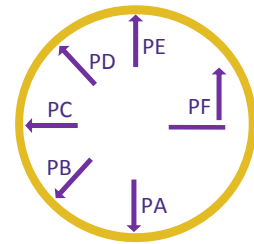
Applications

- Heavy steel fabrication
- Shipbuilding
- Pressure vessels

Features

- Suitable for butt and fillet welding of heavy structure
- Good crack resistance and X-ray performance
- Good mechanical properties

Welding Position



Typical Chemical Properties of All-Weld Metal (%)

C	Si	Mn	P	S	Mo
0.08	0.62	1.22	0.017	0.017	0.005

Typical Mechanical Properties of All-Weld Metal

Ys MPa	TS MPa	EL (%)	Temp °C	Impact Value J
560	620	28.5	-30	80

Diameter mm (in)	2.6 (3/32)	3.2 (1/8)	4.0 (5/32)	5.0 (3/16)
Length mm (in)	350 (14)	450 (18)	450 (18)	450 (18)
F & HF	55-85	90-130	130-180	250-310
V-up, OH	50-80	80-120	110-170	

Current

AC or DC +

Redrying Conditions

300~350°C (572~662°F) X 0.5~1hr

Packing Details

4Kg Pack / 16 Kg Ctn (Vacuum Packing)