

FCW for High Tensile & High Yield Strength Steels

GMX101-K3

AWS A5.29M E691T1-K3C / A5.29 E101T1-K3C
JIS Z 3313 T692T1-1CA-N3M2

Product Features:

- Flux cored arc welding wire for low alloy high yield and high tensile strength steel for all positions.
- All deposited weld metal contains 2.0% Ni-0.5% Mo elements, good for welding of low alloy high yield and high tensile strength steel.
- Good for RT examination, good crack resistance.

Applications:

- Suitable for welding of HY-80 or similar grade steels.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	Ni	Mo	Fe
0.04	0.40	1.40	1.96	0.53	Bal.

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
780	808	16	48

Size (mm) & recommended welding parameters

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~300	200~350
	Vertical / overhead position	160~220	----
Shielding Gas		CO ₂	CO ₂

Note:

- Proper cleaning and 150°C preheat on base metal before welding.
- Keep proper welding current and inter pass temperature to control the heat input (the higher the heat input, the poor the impact toughness).

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
All Right Reserved

GOOD
GOODWELD
www.goodweld.com.tw