

Flux Cored Wire for Chromium-Molybdenum Low Alloy Steels

Welding Notes

1. Preheat, Inter-pass and Post Weld Heat-Treatment Temperature requirement

Product name	Preheat and inter-pass Temperature (°C)	PWHT Temperature × time (°C×1hr)
GMX 811-A1	150±15	620±15
GMX 811B2, GMX 911B3	175±15	690±15

Note : max. inter-pass temperature $\leq 350^{\circ}\text{C}$.

2. Welding current polarity: Electrode Positive (DC+)

3. Proper usages of shielding gas and flow rate as below :

Type of Shielding Gas	Flow Rate L/min	Distance between Contact Tube and Work (min)
CO ₂ or 75~80%Ar+CO ₂	20~25	15~25

4. Recommending low electrical current

To prevent alloy elements burning loss from serious oxidation, welding current should not exceed suggested product limits.

5. For more information, please consult page A40 regarding FCW wire Welding notes for Mild and High Tensile Strength Steel use.