

FCW for Chromium-Molybdenum Low Alloy Steels

GMX811-A1

AWS A5.29M E551T1-A1C
A5.29 E81T1-A1C
ISO 17634-A-T MoL R C1 1

Product Features:

- Titania oxide type flux cored arc welding wire.
- All deposited weld metal contains approximately 0.5% Mo element to get good mechanical property in elevated high temperature.
- Good for RT examination.
- High deposition efficiency.

Applications:

- Suitable for welding of 0.5% Mo grade heat resistant steel.

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

C	Si	Mn	Mo
0.04	0.36	1.19	0.61

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Post Weld Heat Treatment (PWHT) °C / hr
626	678	25	620

Size (mm) & recommended welding parameters

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~300	200~360
	Vertical / overhead position	160~220	180~280
Shielding Gas		CO ₂	CO ₂

Note:

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
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www.goodweld.com.tw