

Flux Cored Wire for Chromium-Molybdenum Low Alloy Steels

GMXK811-A1

AWS A5.29M E551T1-A1C
A5.29 E81T1-A1C

Product Features:

- Titania oxide type flux cored arc welding wire.
- All deposited weld metal contains approximately 0.5% Mo elements 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	0.24	1.04	0.510

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %
611	649	23.3

Size (mm) & recommended welding parameters

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~340	200~380
	Vertical / overhead position	150~220	180~280
Shielding Gas		CO ₂	CO ₂

Note:

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