

Flux Cored Wire for Nickel Steels (low temperature use)

Welding Notes

1. Preheat, Inter-pass and PWHT temperature

Nickel Steel Preheat, Inter-pass and PWHT Temperature Requirement

Product name (°C×1hr)	Preheat and inter-pass Temperature (°C)	PWHT Temperature × time (°C×1hr)
GMX 811-Ni1	150±15	No need
GMX 811-Ni2 GMX 911-Ni3	150±15	No need

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

3. Recommended shielding gas and flow rate chart below :

Type of Shielding Gas (es)	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 (low heat input)

Nickel steel mostly has gone through mechanical properties improvement treatment or normalization heat treatment. Welding parameters must be rigidly controlled using low heat input welding to ensure proper weld metal's alloy element content, strength, impact toughness, and other good properties.

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