

FCW for Nickel Steel (low temperature use)

GMX811-Ni1

AWS A5.29M E551T1-Ni1C
A5.29 E81T1-Ni1C
ISO 17632-A-T46 3Mn1Ni P C1 1

Product Features:

- Titania oxide type gas shield flux cored arc welding wire.
- All deposited weld metal contains approximately 1.0% Ni element, good for serving temperature till -30°C.
- Good for RT examination, good crack resistance.

Applications:

- Suitable for welding of low temperature Ni steel such as A226, A235, A236 for LPG tank.

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

| C | Si | Mn | Ni |
|------|------|------|------|
| 0.05 | 0.21 | 1.28 | 0.95 |

Typical mechanical properties of all-weld metal

| Yield Strength N/mm ² | Tensile Strength N/mm ² | Elongation % | Impact value (-30°C) J |
|-------------------------------------|---------------------------------------|-----------------|---------------------------|
| 572 | 618 | 27 | 92 |

Size (mm) & recommended welding parameters (A) DC±

| Diameter | | 1.2 | 1.6 |
|---------------|-------------------------------|-----------------|-----------------|
| Polarity | | DC+ | DC+ |
| Ampere (A) | Flat, horizontal position | 180~300 | 200~350 |
| | Vertical / over head position | 160~220 | 180~280 |
| Shielding Gas | | CO ₂ | CO ₂ |

Note:

- Proper cleaning and 150°C preheat on base metal before welding.
- Welding procedure detail information such as preheat, inter pass temperature and welding parameters (welding current, voltage, welding speed and base metal thickness etc..) shall be fully followed.

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