

# FCW for Nickel Steels (low temperature use)

## GMX811-Ni2

AWS A5.29M E551T1-Ni2C  
A5.29 E81T1-Ni2C  
ISO 17632-A-T46 4 2Ni P C1 1

### Product Features:

- Titania oxide type gas shield flux cored arc welding wire.
- All deposited weld metal contains approximately 2.4% Ni element, good for serving temperature till -40°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
0.04	0.37	0.94	2.22

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-40°C) J
579	632	27	101

Size (mm) & recommended welding parameters (A)

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~300	200~350
	Vertical / overhead position	160~220	180~280
Shielding Gas		CO <sub>2</sub>	CO <sub>2</sub>

### Note:

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

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