

FCW for Nickel Steels (low temperature use)

GMX911-Ni2

AWS A5.29M E621T1-Ni2C
A5.29 E91T1-Ni2C
ISO 17632-A-T50 4 2Ni P C1 1

Product Features:

- Titania oxide type gas shield flux cored arc welding wire.
- All deposited weld metal contains approximately 2.25% 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 or LPG tank.

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

C	Si	Mn	Ni	Mo
0.03	0.40	1.03	2.26	0.18

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-40°C) J
659	684	23	54

Size (mm) & recommended welding parameters (A)

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~280	200~350
	Vertical / overhead 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.