

FCW for Nickel Steel (low temperature use)

GMX 811-K2M

AWS A5.29M E551T1-K2M
A5.29 E81T1-K2M
ISO 17632-A-T46 6 1.5Ni P M21 1 H5

Product Features:

- GMX811-K2M is a gas shielded all-position flux cored wire featuring low spatter, smooth stable arc, and excellent bead profile.
- Its unique slag system enables to use mixed gas with wide operating parameters .
- It is designed to weld high tensile steel and medium carbon steels with good low temperature impact toughness.

Applications:

- Structural steel, storage tank fabrications, earth moving and agriculture heavy equipment.

Typical chemical composition of weld metal (wt%)

C	Si	Mn	P	S	Ni	Fe
0.03	0.43	1.18	0.016	0.010	1.52	Bal.

Typical mechanical properties of weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (J)
			(-62°C)
620	665	24	88

Size (mm) & recommended welding parameters (A)

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		80%Ar+20%CO ₂	80%Ar+20%CO ₂

Note:

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