

Flux Cored Wire for Weathering Steels

Welding Notes

1. Preheat, Inter-pass and PWHT Temperature

Low Alloy Weathering Steel Preheat, Inter-pass and PWHT Requirement

Product name (°C × 1hr)	Preheat and inter-pass Temperature (°C)	PWHT Temperature × time (°C × 1hr)
GMX 811-W1	150±15	No need

2. Base Metal Surface Cleaning

Grease, dirt, mill scale, and other filthy byproducts on the base metal surface must be thorough cleaned in order to avoid welding defects such as blow holes or pits formation.

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

4. Suitable shielding gas and flow rate are recommended as 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

5. Recommending low electrical current (low heat input)

To prevent the burning loss of alloy elements due to serious oxidation, welding current should not exceed the product recommended limits.

6. For more information, please consult page A40 FCW wire welding notes for mild and high tensile strength steel.