

Flux Cored Wire for Weathering Steels

GMX 811-W2

AWS A5.29M E551T1-W2C
A5.29 E81T1-W2C

Product Features:

- Titanium oxide type gas shield flux cored arc welding wire.
- Weld metal contains Ni, Cr, Cu elements, good for weathering resistance.
- Good for RT examination, good mechanical properties.

Applications:

- Suitable for welding of weathering steels such as ASTM A588, A242 and other weathering steel structures.

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

C	Si	Mn	Cr	Ni	Cu
0.03	0.28	0.61	0.47	0.62	0.52

Typical mechanical properties of all weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-30°C) J
552	609	22	54

Size (mm) & recommended welding parameters

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~300	200~360
	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.
- Proper shelter for wind protection.

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