

# GMX101-K3

## Product Features:

- Flux cored arc welding wire for low alloy high yield and high tensile strength steel for all positions.
- All deposited weld metal contains 2.0% Ni-0.5% Mo elements, good for welding of low alloy high yield and high tensile strength steel.
- Good for RT examination, good crack resistance.

## Applications:

- Suitable for welding of HY-80 or similar grade steels.

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

C	Si	Mn	Ni	Mo
0.05	0.34	1.27	1.89	0.49

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-20°C) J
736	767	20.3	48

Size (mm) & recommended welding parameters

Diameter		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	180~340	180~380
	Vertical / overhead position	150~220	----
Shielding Gas		CO <sub>2</sub>	CO <sub>2</sub>

## Note:

- Proper cleaning and 150°C preheat on base metal before welding.
- Keep proper welding current and inter pass temperature to control the heat input (the

higher the heat input, the poor the impact toughness).

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