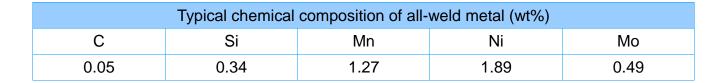
GMX101-K3

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 mechanical properties of all weld metal				
Yield Strength N/mm ²	Tensile Strength N/mm ²	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 ₂	CO ₂	

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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