

## Flux Cored Wire for Nickel Steels (low temperature use)

# GMX811-Ni2

AWS A5.29M E551T1-Ni2C  
A5.29 E81T1-Ni2C

### Product Features:

- Titania oxide type gas shield flux cored arc welding wire.
- All deposited weld metal contains approximately 2.4% Ni elements, good for serving low temperature with good impact toughness.
- Unique slag system enables to use 100% CO<sub>2</sub> shielding gas with wide operating parameters.
- Good for RT examination, Low spatter, smooth stable arc and excellent bead profile.

### Applications:

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

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

C	Si	Mn	Ni
0.05	0.43	1.02	2.23

Typical mechanical properties of all weld metal

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation %	Impact value (-40°C / -50°C ) J
576	639	28	99 / 79.8

Size (mm) & recommended welding parameters

Diameter	1.2	1.6
Current	DCRP	DCRP
Ampere (A)	150~300	200~350
Voltage	23~30	25~32
Shielding Gas	CO <sub>2</sub>	CO <sub>2</sub>

### Note:

- Wire extension Length: 20~30mm
- Welding procedure detail information such as preheat, inter pass temperature and all welding parameters ( welding current, voltage, welding speed, base metal thickness etc..) shall be fully followed.

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