

Characteristics and Applications:

It is a kind of self-shielded flux cored wire for 490MPa high strength, it exhibits high deposited rate, easy match for parent material, easy erecting for welding equipment, high flexibility, simple equipment operation, excellent X-Ray inspection, it is a kind of excellent welding consumable for high speed vertical welding. It is usually used in the fast welding of heavy plate 'I shape or T shape' joint, such as steel construction, box pillar, reinforcement plate.

Welding Position: 

Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	Cu	V
AWS	-	1.70	0.50	0.20	0.30	0.35	0.03	0.03	0.08	0.08
Tested	0.065	1.45	0.30	0.02	0.01	0.16	0.010	0.008	0.01	0.01

Typical Mechanical Properties of Weld Metal:

Mechanical Property	Yield Stress (MPa)	Tensile Strength .S. (MPa)	Elongation (%)	Impact values (J/°C)
AWS	350	480-650	-	27J /-3 0°C
Tested	470	580	-	65J /-3 0°C

Notes on Usage:

- 1.Polarity : DC+.
- 2.In welding, try to use consumption tube with equivalent composition.
- 3.When welding with consumption tube without insulation coating, insulation ring should be affixed to avoid of short circuit.
- 4.The workpiece should be preheated in welding heavy plate to make sure the sound weld and wettability in the edge of parent material.
- 5.Tightness of baffle should be assured, in avoid of the release of molten iron.
- 6.Shape of joint, material of tube, welding process, cooling rate will affect the strength of weld, so, the above parameter should be controlled.

Sizes Available and Recommended Parameters:

Diameter/mm	1.6		2.4		3.0			
Thickness of Plate(mm)	9	12	12	19	20	25	38	50
Feeding wire Speed(cm/min)	280	300	350	400	510	580	750	890
Volt	30	32	36	38	35-38	38-40	42-44	42-44