

## Characteristics and Applications

For all-position welding of 590 N/mm<sup>2</sup> high tensile steel, it is suitable for root pass welding of pipes and commonly applied in welding Mn-Mo Mn-Mo-Ni alloy high tensile steel.

## Notes on Usage

1. 100% Argon shielding gas with 99.997% high purity is recommended and the flow rate must be properly controlled. The recommended flow rate is 7-12l/min when arc current is 100-200Amp and it goes up to 12-15l/min when arc current rises to 200-300Amp.
2. Trailer Shield is required to ensure the weld pool completely shielded by inert gas until solidification is complete and no porosity problem.
3. Select right gas cup size and employ proper stick out of tungsten electrode.
4. Be sure to clean up the contaminations on the base metal and welding seam so as not to derogate the weld metal quality from particles.

## Typical chemical composition of wire (wt%):

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu
0.10	1.1	0.60	0.011	0.010	0.85	0.07	0.02	0.002	0.1

## Typical mechanical properties of all weld metal:

Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-1bf) -46°C (-51 )
480(70)	580(84)	32	200(148)

## Sizes available:

Diameter (mm)	1.6	2.0	2.4	3.2

SOLID W

WIRES

and TienTai Electrode Co., Ltd. reserves the right to change specifications without notice. Other tests and procedures may produce different results. Electrode Co., Ltd.

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