

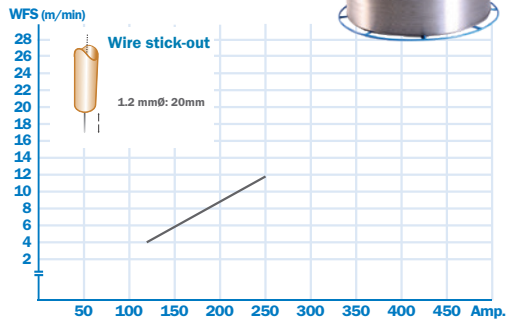
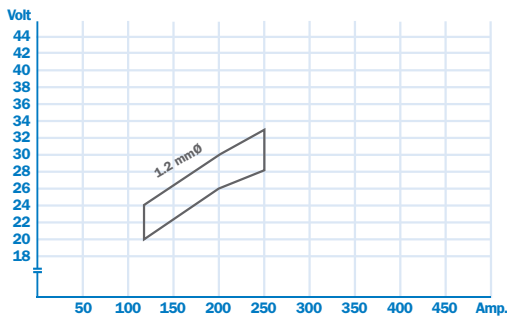
Description and Application

This is a rutile flux cored wire which operates with a very stable, spatter free arc producing bright, smooth weld bead surfaces with self releasing slag.

This wire is designed for welding 18%Cr-10%Ni stainless steels for cryogenic use like liquified natural gas (LNG) tanks.



Recommended Parameter Range, for flat position*



Typical Chemical Analysis (wt. %)*

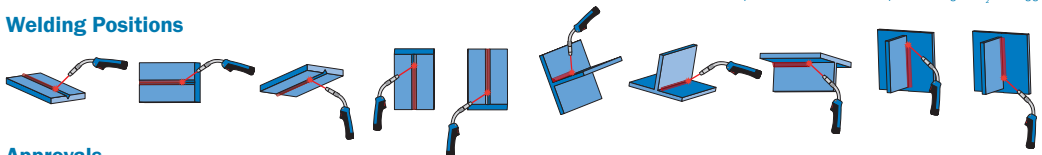
| C | Si | Mn | P | S | Ni | Cr | Mo | N | Nb | FS | FN | FNW |
|------|------|------|-------|-------|------|------|----|---|----|-----|-----|-----|
| 0.03 | 0.70 | 1.40 | 0.016 | 0.002 | 10.1 | 19.0 | - | - | - | 6.8 | 7.6 | 5.3 |

Typical Mechanical Properties*

| | R _e (MPa) | R _m (MPa) | A ₅ (%) | CV (J) | L.E.(mm) | CV (J) | L.E.(mm) | CV (J) | L.E.(mm) |
|----------|----------------------|----------------------|--------------------|--------|----------|----------|----------|--------|----------|
| | | | | 0°C | | -100°C | | -196°C | |
| | | | | 61 | 1.12 | 51 | 0.82 | 42 | 0.45 |
| Guaranty | min.320 | min.520 | min.30 | min.27 | | min.0.34 | | | |

* The above values and parameters are for all weld metal produced using Ar+CO₂ shielding gas

Welding Positions



Approvals

| LR | DNV GL | BV | ABS | R.M.R.S | Others |
|----|--------|----|-----|---------|--------|
| - | - | - | - | - | CE |