

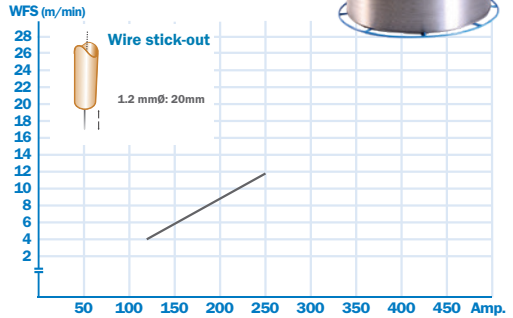
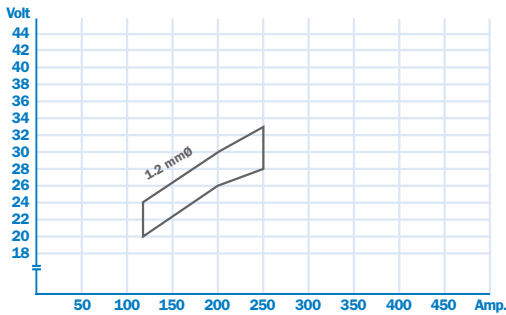
## Description and Application

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

The wire is designed for welding 18%Cr-12%Ni-2.5%Mo stainless steels for cryogenic use like liquified natural gas (LNG) tanks.



### Recommended Parameter Range, for flat position



### Typical Chemical Analysis (wt. %)\*

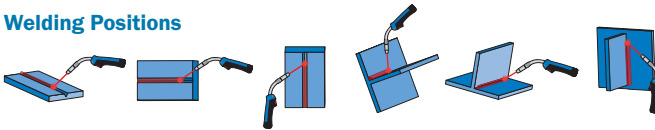
| C    | Si   | Mn   | P     | S     | Ni   | Cr   | Mo   | N | Nb | FS  | FN  | FNW |
|------|------|------|-------|-------|------|------|------|---|----|-----|-----|-----|
| 0.03 | 0.40 | 1.20 | 0.021 | 0.008 | 12.4 | 17.6 | 2.20 | - | -  | 2.7 | 4.8 | 4.3 |

### Typical Mechanical Properties\*

|          | CV (J)               |                      |                    | L.E.(mm) |          | CV (J) |      | L.E.(mm) |      |
|----------|----------------------|----------------------|--------------------|----------|----------|--------|------|----------|------|
|          | R <sub>e</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | 0°C      |          | -100°C |      | -196°C   |      |
|          |                      |                      |                    | 74       | 1.51     | 53     | 0.96 | 34       | 0.59 |
| Guaranty | min.320              | min.510              | min.25             | min.27   | min.0.34 |        |      |          |      |

\* The above values and parameters are for all weld metal produced using Ar+CO<sub>2</sub> shielding gas

### Welding Positions



### Approvals

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