

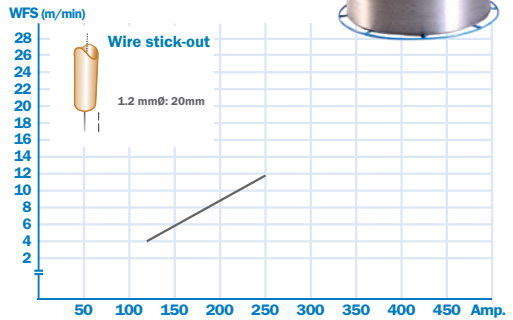
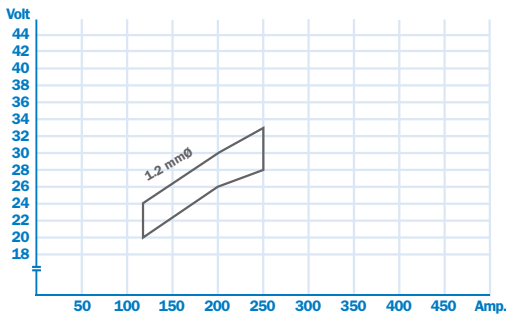
Description and Application

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. %)*

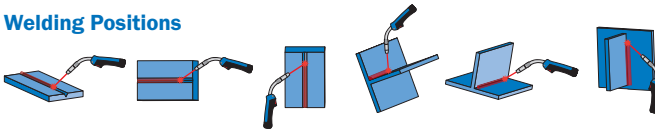
| C | Si | Mn | P | S | Ni | Cr | Mo | N | Nb | FS | FN | FNW |
|------|------|------|-------|-------|------|------|------|---|----|-----|-----|-----|
| 0.03 | 0.40 | 1.20 | 0.021 | 0.008 | 12.4 | 17.6 | 2.20 | - | - | 2.7 | 4.8 | 4.3 |

Typical Mechanical Properties*

| | CV (J) | | | L.E.(mm) | | CV (J) | | L.E.(mm) | |
|----------|----------------------|----------------------|--------------------|----------|----------|--------|------|----------|------|
| | R _e (MPa) | R _m (MPa) | A ₅ (%) | 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+CO₂ shielding gas

Welding Positions



Approvals

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