

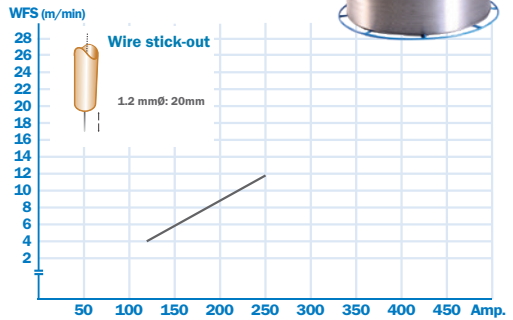
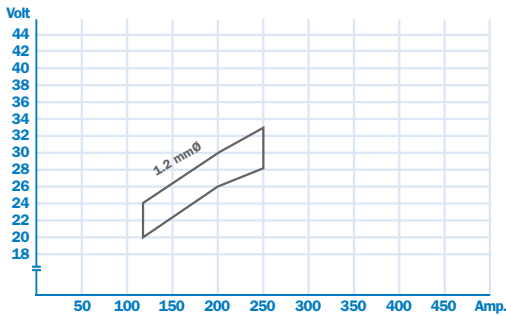
## Description and Application

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. %)

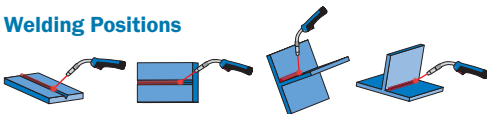
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.50	2.30	0.018	0.007	10.3	18.6	-	-	-	3.0	4.8	5.0

### Typical Mechanical Properties\*

	CV (J)			L.E.(mm)		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		CV (J)		L.E.(mm)	
Guaranty	380	530	51	69	1.40	51	0.92	39	0.52				
	min.320	min.520	min.30			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
-	-	-	-	-	-