

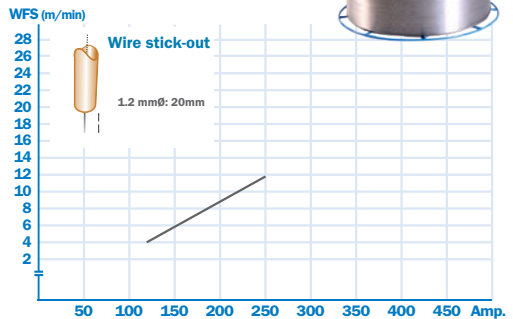
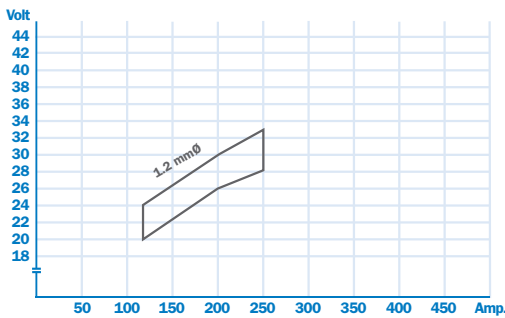
## Description and Application

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. %)\*

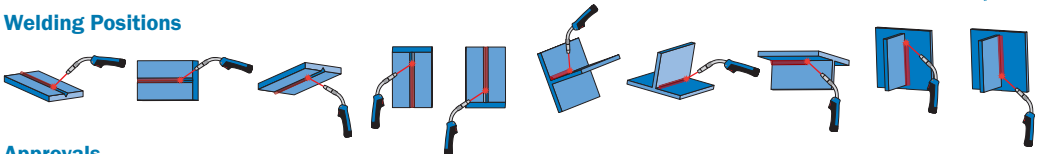
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.70	1.40	0.016	0.002	10.1	19.0	-	-	-	6.8	7.6	5.3

### Typical Mechanical Properties\*

	R <sub>e</sub> (MPa)	R <sub>m</sub> (MPa)	A <sub>5</sub> (%)	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+CO<sub>2</sub> shielding gas

### Welding Positions



### Approvals

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