

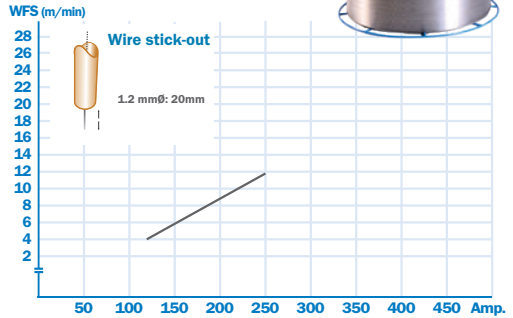
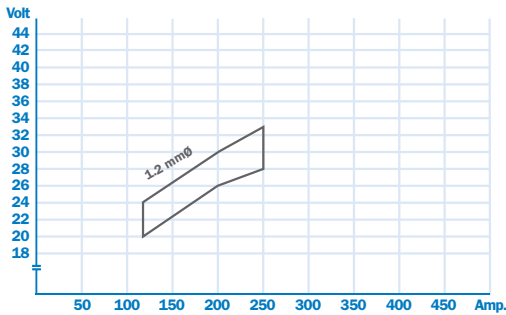
Description and Application

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. %)*

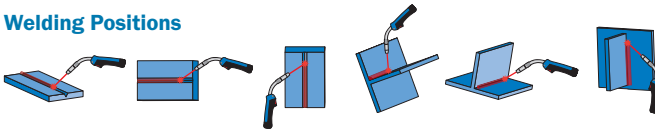
C	Si	Mn	P	S	Ni	Cr	Mo	N	Nb	FS	FN	FNW
0.03	0.40	1.20	0.021	0.008	12.4	17.6	2.20	-	-	2.7	4.8	4.3

Typical Mechanical Properties*

	CV (J)			L.E.(mm)		CV (J)		L.E.(mm)		CV (J)		L.E.(mm)	
	R _e (MPa)			R _m (MPa)		A ₅ (%)		0°C		-100°C		-196°C	
	396			542		41		74		53		34	
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 GL	BV	ABS	R.M.R.S	Others
-	-	-	-	-	-