

Applications

Used for welding of LNG storage tank. (welding for 9%Ni steel), FPSO

Characteristics on Usage

- ① Having good toughness at cryogenic temperature.
- ② Provide excellent strength in various temperature range.
- ③ Stable arc and smooth bead appearance.

Shielding Gas

Ar, Ar+He

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Cu	W
0.014	0.012	0.010	0.002	0.001	2.0	70.20	19.4	0.01	2.62

Typical Mechanical Properties of All-Weld Metal

TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
725 (105,100)	38.0	-196 (-321)	176 (130)

Packing

SMT-08	MIG	Size(mm)	1.0	1.2	1.6
		Weight	Spool: 12.5kg		
	TIG	Size(mm)	2.0	2.4	3.2
		Weight	5kg*1,000mm		