

- ③ It provides smooth arc and low spatter generation, good slag removal in using shielding gas 75~80%Ar+CO2.
- ④ It is free from porosity and good radiographic soundness.
- (5) Refer to page 150 for more information on usage.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	С	Si	Mn	Р	S
Ar+20%CO2	0.03	0.12	0.80	0.013	0.012

Typical mechanical properties of all-weld-metal

Shielding Gas	Υ·Ρ	Τ·S		Charpy V-notch
	N/mm²{kgf/mm²}	N/mm²{kgf/mm²}	(%)	J {kgf ⋅ m} (0°C)
Ar+20%CO2	395 {40}	487 {49}	31	30 {3}

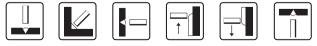
Sizes available and recommended currents (DC wire \oplus)

Dia.	(mm)	1.2	1.4	1.6
	F	140~340A	180~440A	200~460A
Amp.	Н	140~340A	180~440A	200~460A
	V	140~260A	180~260A	200~260A

Package

Dia.	(mm)	1.2		1.4	1.6
Spool	(kg)		5	, 12.5, 15, 20	

Welding positions



Approved by