AFR-X80-O

AWS A5.29 E81T8-Ni2J H8
EN ISO 17632-A T46 3 2Ni Y N 1
GB T17493 E551T8-Ni2J H8

FLUX CORED SELF-SHIELDED WIRES FOR LOW TEMPERATURE LOW ALLOY STEEL

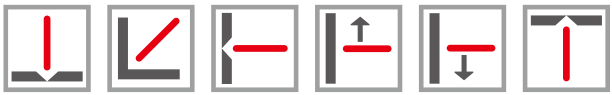
DESCRIPTION & APPLICATIONS :

- AFL-X80-O is a self-shielded low alloy flux core wire designed for 490N/mm^2 grade steel. The weld metal of SFC-81A1 is 2%Ni.
- Deep arc penetration, nice bead appearance, easy spatter off. especially suitable for vertical down position because the bead solidify quickly.
- With excellent low temperature impact toughness, good crack resistance, high efficiency of weldability.
- Suitable for high requirement of low temperature impact toughness X80 pipe.

NOTE ON USAGE :

- Use DC(-) polarity.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Al
0.05	1.10	0.07	0.010	0.003	1.83	1.01

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm^2(Kgf/mm^2)	TENSILE STRENGTH N/mm^2(Kgf/mm^2)	ELONGATION RATE %	IMPACT VALUES -40 °C J(Kgf-m)
485(49.5)	578(58.9)	24	110(11.2)

SIZE AND RECOMMENDED CURRENT RANGE : DC(-)

Parameters \ Diameter (mm)	1.6	2.0
Voltage (Volt)	16-20	16-20
Current (Amp)	180-250	180-280
Stickout (m/m)	10-20	10-20