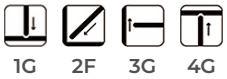
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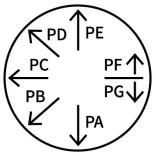
Classification

AWS AWS A5.29 / ASME SFA-5.29 E81T1-Ni1C-J, -Ni1M-J H4

EN ISO 17632-A T46 4 1Ni P C1/M21 1 H5

Welding Positions





Features

- Designed for welding with 100%CO2 and Ar+20~25%CO2 shielding gas
- Smooth arc and low spatter, good weldability
- Good bead appearance
- Slag covering is uniform and easy to remove

Polarity

DC +

Application Areas

- Mining machinery
- Steel industry

Shielding Gas

100% CO2

Ar+20% CO2

Typical Chemical Composition of All-Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S	Ni
100% CO2	0.04	0.38	0.98	0.010	0.010	0.85
Ar+20% CO2	0.05	0.50	1.15	0.010	0.010	0.83

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	505 (73)	560 (81)	31	-40 (-40)	55 (41)
Ar+20% CO2	580 (84)	640 (93)	29	-40 (-40)	75 (55)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	110~280	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs)
1.6 (1/16)	120~300	Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)