Metal Cored Wire for Low Temperature Alloy

KMX- 80Ni1

Shielding Gas: 98%Ar+2 %O_2

Classification

AWS	A 5.28/A5.28M	E80C-Ni1/ E55C-Ni1
JIS	Z3313	T554T15 1CA N2
EN	17632-A	T50 4 1Ni M13 3 H5
GB	T17493	E55C-Ni1

Applications and Features

(1) Suitable for welding 550N/mm^2 grade steel.

(2) Compared with flux cored wire, KMX-80Ni1 has higher deposition rate, faster travel speed, superior arc wetting and better bead appearance.

(3) Excellent toughness at -45℃ due to 1% Ni content.

(4) Ideal for welding LPG tank, such as A226, A235 and A236.

Welding position

Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Ni
0.05	0.43	1.41	0.019	0.006	0.93

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm^2	N/mm^2	%	℃	J
611	532	27	-29	90
			-45	72

Size and Suggested Operating Range (DC+)

Diameter (mm)		1.2	1.4	1.6
Current (A)	F/HF	180~350	200~400	350~600