FCW NI3B

Flux Cored Wire

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Classification

AWS A5.29: E81T5G-H4

EN ISO 17632-A : T 46 10Ni B M 3 H5

EN ISO 17632-B : T 5510T5 0GP N7-UH5

Characteristics

Flux cored wire for semi-automatic Gas shielded arc welding containing 3.5 % nickel alloyed to improve sub-zero impact strength. It is use for single and multiple pass welding of cold tough/fine-grained steels. Diffusible hydrogen guaranteed < 4 ml/ 100g deposited metal with complete range of welding parameters. Excellent wire feeding properties, Good weldability with low spatter.

Applications

Tough at subzero steels 12Ni14 / 10Ni14 / 16Ni14 ASTM A350 gr.LF3, A 352 gr. LC3, A 333 gr. 3, A203 gr. B ISO/TR 15608: Group 9.1

Weld metal analysis % (Typical)

C	Mn	Si	P	S	Ni
0,04	0,60	0,25	0,015	0,010	3,22

Mechanical properties of the pure weld metal (Typical)

Heat-treatment	$R_{p0.2}$ MPa	R_m MPa	A5 %	Charpy V Notch [J] - 100°C
SR	475	555	28	95

SR: 620°C at 1 hour

Welding Parameters

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick out [mm]	Shielding Gas
1.2	DC(+) Pulsed	90 - 340	15 - 34	12 - 25	M20 Ar + 20% CO_2 Or CO_2 18-20 l/min
1.6		120 - 460	16 - 35	15 - 25	