

AT-X80						
CONFORMANCES & APPROVALS	AWS A5.36 E91T8-A2-G; AWS A5.36M E621T8-A3-G; GB/T 17493 E621T8-G					
DESCRIPTIONS	<ol style="list-style-type: none"> 1. Self-shielding flux-cored wire for all welding positions; 2. As-weld deposit with great impact toughness @ -20°C; 3. Excellent operator appeal; 4. Fast freezing and removal slag; 5. Good for outdoor welding. 					
APPLICATIONS	<ol style="list-style-type: none"> 1. Offshore platform structure in the low temperature zone; 2. Circumferential welding API X80 Grade pipeline laying; 3. Automatic and semi-automatic welding mild steel, weathering resistant steel and high tensile strength steel. 					
KEY FEATURES	<ol style="list-style-type: none"> 1. Self-shielding, and no shielding gas required; 2. Good for outdoor welding 3. 90~150°C Pre-heating is required in the pipeline welding; 4. DCEN. 					
TYPICAL COMPOSITION OF DPOSIT (wt%)						
C	Mn	Si	S	P	Al	Ni
0.046	1.42	0.07	0.003	0.007	0.92	3.50
TYPICAL MECHANICAL PROPERTIES OF DEPOSIT						
Tensile Strength R _m (MPa)	Yield Strength R _{el} (MPa)		Elongation A (%)		Charpy V-Notch Akv@-30°C (J)	
720	670		21		106/133/102	
TYPICAL WELDING PROCEDURE PARAMETERS						
Diameter (mm)	Current (A)		Voltage (V)		Wire Feed Speed (in/min)	
2.0	160~260		16~23		80~110	
PACKAGE: <ol style="list-style-type: none"> 1. Coil, 6kg/coil; 2. Barrel, containing 4 coils, 24kg/barrel. 						
Price						