

35.45.Nb

MIG (GMAW)

SOLID WELDING WIRE FOR MIG WELDING

PRODUCT DESCRIPTION

Straight lengths and spooled wire for manual and automatic MIG welding.

CLASSIFICATIONS

There are no national specifications for this wire.

ASME IX QUALIFICATION

QW432 F-No --
QW442 A-No --

CHEMICAL COMPOSITION (WELD METAL WT %)

	C	Mn	Si	S	P	Cr	Ni	Nb	Mo	Ti	Zr	Fe
min.	0.40	0.8	1.0	-	-	34	44	0.6	-	0.04	-	-
max.	0.50	1.5	1.6	0.015	0.02	38	48	1.3	0.50	0.15	0.15	bal
Typical	0.43	1.0	1.2	0.005	0.012	36	46	0.9	0.05	0.1	0.05	13

ALL-WELD MECHANICAL PROPERTIES

As welded	Typical
Tensile strength (MPa)	690
0.2% proof strength (MPa)	550
Elongation (%) 4d	3
Hardness (HV)	280

TYPICAL OPERATING PARAMETERS

Shielding gas	Current	Diameter (mm)	Parameters
Argon	DC-	2.4	120A, 12V

PACKAGING DATA

Diameter (mm)	Weight (kg)	Packaging	Item number
1.2	15	S300	M3545NB-12

FUME DATA (WT % TYPICAL)

Fe	Mn	Cr ³	Ni	Mo	Cu	OES (mg/m ³)
15	5	28	28	<0.5	<0.5	1.8

HIGH TEMPERATURE ALLOYS