

SAFDUAL 128V

TOP FEATURES

- Suitable for the welding of fine-grain structural steels for operating temperatures from -50°C up to +450°C.
- Very good slag removal, smooth seam surface without undercutting into the base metal.
- Very good mechanical property values and highly X-ray proof.
- Can be welded in all positions with one setting of parameters.

TYPICAL APPLICATIONS

- Offshore
- Shipbuilding

CLASSIFICATION

AWS A5.29 E91T1-GM

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ 15-25% CO₂

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

C	Mn	Si	P	S	Ni
0.05	1.3	0.4	≤0.015	≤0.015	0.85

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -50°C
Typical values	M21	AW	≥550	620-760	≥22	≥50

* AW = As welded

Gas test: 82% Ar+18% CO₂

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.0	SPOOL (S200)	5.0	W000375216

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application.

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing. Please refer to www.lincolnelectric.eu for any updated information.