

FLUX CORED SELF-SHIELDED WIRES FOR LOW TEMPERATURE LOW ALLOY STEEL

DESCRIPTION & APPLICATIONS :

- AFL-X70-O is a self-shielded low alloy flux core wire designed for 490N/mm² grade steel.
- Suitable for low alloy steel, X70 pipe, outdoor carbon steel welding.

NOTE ON USAGE :

- Use DC(-) polarity.

WELDING POSITION :



TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :

C	Mn	Si	P	S	Ni	Al
0.06	1.13	0.12	0.011	0.004	0.82	1.14

TYPICAL MECHANICAL PROPERTIES OF WELD METAL :

YIELD POINT N/mm ² (Kgf/mm ²)	TENSILE STRENGTH N/mm ² (Kgf/mm ²)	ELONGATION RATE %	IMPACT VALUES -40 °C J(Kgf-m)
424(43.3)	523(53.4)	28	120(12.2)

SIZE AND RECOMMENDED CURRENT RANGE : DC(-)

Parameters \ Diameter (mm)	1.6	2.0
Voltage (Volt)	16-20	16-20
Current (Amp)	180-250	180-280
Stickout (m/m)	10-20	10-20