

## WELDSKILL GASLESS WELDING WIRE



- Self-shielded flux cored wire
- For single pass and multiple pass applications
- Versatile, all positional capabilities
- Excellent tolerance to joint misalignment or poor joint fit-up
- Smooth rippled fillets with good edge wetting
- Ideal for welding thin section mild and galvanised steels

### Classifications:

AS/NZS 2203.1: (old) ETPS-GNn-W500A CM2

AS/NZS ISO 17632: (new) B T 49 Z T11 1 N A

AWS/ASME-SFA A5.20: E71T-11

### TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Yield Stress	435 MPa
Tensile Strength	580 MPa
Elongation	22%

### TYPICAL WIRE ANALYSIS:

C: 0.25%	Mn: 0.70%	Si: 0.3%
Al: 1.9%	S: 0.004%	P: 0.007%

### TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:

15.0-20.0 mls of hydrogen/100gms of deposited weld metal\*

### RECOMMENDED SHIELDING GAS:

Not required

\*for 'as manufactured' product using the recommended ESO lengths

Actual weld metal mechanical properties achieved with WeldSkill Gasless Wire are influenced by many factors including base metal analysis, welding parameters/heat input used, number of weld passes and run placement, etc. Please consult Customer Care for welding procedure recommendations.

### Packaging and Operating Data:

Wire Dia. mm	Voltage Range (volts)	Current Range (amps)	Electrode Stickout (ESO)	Pack Type* Weight	Pack	Part No
0.8	14-16	60-120	10-12	Minispool	0.9kg	WG0908
				Handispool	4.5kg	WG4508
0.9	15-17	80-150	12-15	Minispool	0.9kg	WG0909
				Handispool	4.5kg	WG4509
1.2	16-18	130-180	15-20	Handispool	4.5kg	WG4512

\*Minispool (ø 100mm); Handispool (ø 200mm)