

Typical mechanical properties of weld metal:

Mechanical properties	Y.S. (MPa)	T.S. (MPa)	El (%)	CVN (J/°C)	PWHT (°C x h)
GB/T	420	500	22	27/-30	AW
AWS	400	480	22	27/-30	AW
EXP	460	570	31	84/-30	AW
	405	525	32	95/-30	580x5

Typical chemical composition of weld metal

wt %	C	Mn	Si	Cr	Ni	Mo	P	S	Cu
GB/T	0.06-0.15	1.4-1.85	0.8-1.15	-	-	-	0.025	0.035	0.50
AWS	0.06-0.15	1.4-1.85	0.8-1.15	0.15	0.15	0.15	0.025	0.035	0.50
EXP	0.078	1.45	0.85	0.02	0.01	0.01	0.012	0.010	0.20

Sizes Available and recommende parameters

Dia/mm	0.6
Current Amp E.H	100-200
Current Amp OH.V	60-100