

CSM-80K2

For 550N/mm² class high strength steel and low temperature steel

AWS	A5.29	E80T1-K2C
KS	D 7104	YFL-C506M
JIS	Z3313	T556T15-0CA-N3-H5

Applications

Butt, fillet welding of 550N/mm² class high strength steel and low temperature steel of structure such as ships, bridges, buildings and storage tanks etc.

Characteristics

- (1) CSM-80K2 is a metal type flux cored wire for flat & horizontal fillet welding with CO₂ gas shielding.
- (2) Its deposition rate is 10~30% higher compared with a solid wire.
- (3) It provides excellent impact value at low temperatures down to -60°C.

Notes on usage

- (1) The optimum flow of CO₂ for shielding is 20~25ℓ/min.
- (2) The distance between tip & base metal is to be 15~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (4) Thick heavy plate should be welded under proper preheating & interpass temperature.

Typical chemical composition of weld metal (%)

(Shielding gas : 100%CO₂)

C	Mn	Si	P	S	Ni
0.05	1.45	0.45	0.012	0.011	1.50

Typical mechanical properties of weld metal

(Shielding gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)	
			-30°C	-60°C
550	625	27.0	85	58

Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400

• Approval : DNV, LR