

# CSF-ANCOR

For corrosion-resistant steel at sulfuric acid environmental conditions.

AWS A5.29 E71T-GC

## Applications

Butt, fillet welding of corrosion-resistant steel at sulfuric acid environmental conditions such as thermal power plant, bridges and storage tanks etc.

## Characteristics

- (1) CSF-ANCOR is a titania type flux cored wire and designed for all-position welding by single pass & multi pass with CO<sub>2</sub> gas shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.

## Characteristics

- (1) The optimum flow of CO<sub>2</sub> 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.

## Typical chemical composition of weld metal (%)

(Shielding gas : 100%CO<sub>2</sub>)

C	Mn	Si	P	S	Cu	Cr	Ni	Co
0.05	0.80	0.35	0.013	0.009	0.35	0.26	0.21	0.19

## Typical mechanical properties of weld metal

(Shielding gas : 100%CO<sub>2</sub>)

YP N/mm <sup>2</sup> (MPa)	TS N/mm <sup>2</sup> (MPa)	EL %	[Hi Temp.] TS N/mm <sup>2</sup> (MPa)	Corrosion Test *	IV (J) 0°C
582	636	25.4	424 (500°C)	12	98

\* Corrosion test : hydrochloric & sulfuric acid environmental conditions (50%, 70°C)

## 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
	V-up	120~220	160~260	160~260
	V-down	120~240	160~260	160~280
	OH	120~220	140~260	160~260