

NB-55E × Y-D

☆AWS A5.17 F7A8-EH14

for Low Temperature Service Steel

APPLICATIONS

Single-layer welding of aluminium-killed steel for low temperature service for offshore structures, ships and LPG storage tanks.

CHARACTERISTICS

Excellent toughness is obtained in multi-layer welding with 30~100kJ/cm heat input.

GUIDELINES FOR USAGE

Flux should be used as fast as possible after taking out of the can. Flux should be redried at 250~350°C for 60 minutes.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	P	S
0.09	0.18	1.65	0.018	0.007

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Tensile Test			Charpy 2 V-notch, J		Base Metal	Plate Thickness mm	Welding Method
Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	-60°C	-40°C			
460	560	33	170	200	EH36	32	X groove

■ TYPICAL GROOVE GEOMETRY AND WELDING CONDITIONS

Plate Thickness mm	Wire Dia mm	Groove Geometry	Pass	Current A	Voltage V	Speed cm/min	Note
25	(L) 4.8 (T) 6.4		1	(L) 1000 (T) 900	36 40	60	One pass both sides
			2	(L) 1100 (T) 850	36 40	55	
32	(L) 4.8 (T) 6.4		1	(L) 1080 (T) 1000	36 40	45	One pass both sides
			2	(L) 1250 (T) 1100	36 40	45	

Approval: NK, ABS, LR, DNV