

Formula XL-525



SUMMARY

- > Low Diffusible Hydrogen
- > Excellent Toughness at Low Temperatures
- > Outstanding Weldability
- > Exceeds 47J CVN @ -40°C

CLASSIFICATION

- > AS/NZS ISO 17632-B - T494T1-1MA-U H5
- > AS/NZS ISO 17632-B - T494T12-1MA-U H5
- > AWS A5.20: E71T-1M, E71T-12MJ H8

DESCRIPTION AND APPLICATION

A rutile flux cored all position wire designed for welding mild and carbon steels, especially when good impact toughness is required at sub zero temperatures. Ideal for single and multi-pass applications, it delivers outstanding welding performance and produces high quality X-ray clear weld deposit with a bead contour that is flat to slightly convex. It performs exceptionally well over rust, mill scale and some primers with no pre-cleaning of the steel necessary. Formula XL-525 has outstanding mechanical properties that resemble those of E7018 MMAW (SMAW) electrodes, plus high operator appeal with low fume levels, low spatter and easy slag removal.

Recommended for ship building, storage vessels, off-shore structures, earth moving equipment and pipe welding.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	150 - 300	24 - 31
1.6	200 - 350	24 - 34

Recommended electrical stick out is 15-20mm.

Welding Current DC +

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

SHIPPING APPROVAL

LR 3S, 3YS; ABS 3SA, 3YSA Impact @ -40°C 34 ft, lbs
 DNV Y40MS BVS 3YM; CWB E491T-12MJ-H4;

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	Ni	Fe
0.03	1.10	0.30	0.34	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	Ar+20% CO ₂
Yield Stress	503 MPa
Tensile Strength	566 MPa
Elongation	29%
CVN Impact Values	90J @ -40°C

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	15kg Spool	S283212-029
1.6	15kg Spool	S283219-029

The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Welding Industries of Australia expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with the AWS and or AS/NZS specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique by Welding Industries of Australia.

Issue CA - December 2014