

NB-250J × Y-80J

☆JIS Z 3183 S804-H4
☆AWS A5.23 F11A10-EG-G

For 780MPa High Tensile Strength Steel

APPLICATIONS

Welding of 780MPa high tensile strength steel for offshore structures, pressure vessels, penstocks and bridges.

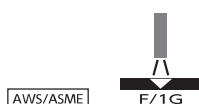
CHARACTERISTICS

NB-250J is a bonded flux designed to minimize the diffusible hydrogen content in weld metal and, therefore, crack resistance is extremely high. Impact properties are excellent at low temperature and slag is easy to remove even in narrow grooves.

GUIDELINES FOR USAGE

1. Flux should be redried at 250~350°C for 60~120 minutes before use.
2. When flux is reused, care should be taken that alien things such as rust are not mixed in with the flux.
3. Preheating at 100~150°C is required.

WELDING POSITION



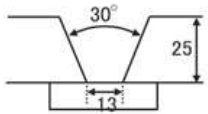
■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

C	Si	Mn	Ni	Cr	Mo	Base Metal	Plate Thickness mm	Welding Method
0.08	0.20	1.43	2.17	0.56	0.52	WT780	25	Multi-layer

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Joint Tensile Test			Charpy 2 V-notch, J		Base Metal	Plate Thickness mm	Heat Input kJ/cm	Welding Method
Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	-60°C	-40°C				
759	859	24	64	103	WT780	25	34	Multi-layer

■ TYPICAL GROOVE GEOMETRY AND WELDING CONDITIONS

Plate Thickness mm	Wire Dia. mm	Groove Geometry	Pass	Current, A	Voltage, V	Speed, cm/min	Note
25	4.0		1~8	600	28	30	Multi-layer