

GFC 91K2

IDENTIFICATION

GFC 91K2, E91T1K2C

CLASSIFICATION

AWS/SFA 5.29: E91T1K2C

DESCRIPTION

GFC 91K2 is designed for welding of 620 MPa high tensile steel with slow freezing slag system. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications. Tubular rutile flux-cored all position wire for single or multipass welding of carbon, carbon-manganese steels and similar types of steels, including fine grain ones, with CO₂ shielding gas. The good weldability in all positions, excellent bead appearance, less spatter, a fast freezing and easy to remove slag.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	V	Cr	P	Ni	Mo
0.15 max	1.75 max	0.80 max	0.03 max	0.05 max	0.04 max	0.03 max	1.0 - 2.0	0.35 max

MECHANICAL PROPERTIES (RANGE)

PWHT	TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
				Temp	Joules
As welded	620 min	550 min	17 min	-40°C	70
				-30°C	120
				-20°C	80

TYPICAL APPLICATIONS

- Ship building, railways wagons, general fabrication welding, pipe welding, bridges, automobile parts, tanks etc.
- Welding of high tensile steel offshore structure, etc.

SHIELDING GAS : CO₂

FLOW RATE : 15 - 20 l/min

PACKING PARAMETERS

Size (mm)	Amps DC (+)	(Voltage)	Weight / Spool (kg)
1.2	180 - 300	24 - 36	15