

SMT-08

Conformances

AWS A5.14/ ASME SFA5.14 ERNiMo-8
 JIS Z3334 SNI1008 (NiMo19WCr)
 KOGAS
 ABS AWS A5.14 ERNiMo-8
 DNV-GL VL1.5Ni up to VL9Ni
 RS Manufacturer's Spec. (-196°C)

Applications

- LNG storage tanks
- Oxygen, nitrogen and LNG carriers

Features

- For the automatic welding processes for a LNG storage tank with a methode of GTAW for vertical joints of side plates(ASTM A333,A334,A353,A553)
- Impact toughness at extra low temperature

Welding Position

Current

GTAW: DC-(Auto TIG)

Shielding Gas

Ar

Diameter / Packaging

Diameter	MIG	TIG
mm (in)	12.5kg (27.8lbs)	5kg (11lbs)
1.2 (0.045)	√	
2.0 (5/64)		√
2.4 (3/32)		√
3.2 (1/8)		√

Typical Chemical Composition of the Wire (%)

C	Si	Mn	P	S	Cr	Ni	Mo	Fe	W
0.015	0.012	0.01	0.002	0.001	2.1	69.8	19.2	5.6	2.6

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)
-	725 (105,000)	38.0	-196 (-321)	150 (111)

Typical Welding Parameters

Diameter, Polarity Shielding Gas	Amp. (A)	Volt. (V)
	1.2mm (0.045 in) DC-(Auto-TIG)	
Ar	160	28
	2.4mm (3/32 in) DC-	
Ar	110	12

SMAW

SAW

GMAW

GTAW

FCAW

Non-FERROUS

APPENDIX