

Characteristics and Applications:

HOBART 811K2 is a titania type flux-cored wire, is designed for welding 560 N/mm² high tensile steel for low temperatures. The weld metal contains about 1.5%-Ni and makes good notch toughness at temperatures down to -60°C under as-welded condition.

It provides excellent usability with stable arc and efficiency in all-position welding.

It is suitable for butt or fillet welding of offshore structures for low-temperature applications, LNG and LPG carriers, and storage tanks, etc.

Notes on Usage:

1. When the heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input depending on the required impact value.
2. Use DCEP(DC+) polarity.
3. Use 99.8% or higher purity of CO₂ gas.

APPROVALS:

DNV:V Y46MS(H5)

Typical Chemical Composition of Weld Metal (wt%)

C	Mn	Si	P	S	Ni
0.042	1.21	0.25	0.009	0.008	1.64

Typical Mechanical Properties of Weld Metal

Yield stress (MPa)	Tensile strength (MPa)	Elongation (%)	Charpy V-Notch	
			-40°C (J)	-60°C (J)
520	590	26	146	86

Sizes and recommended current range (DCEP):

Stick out:15-25(mm), flow rate:20-25(L/min):

Diameter (mm)	1.2	1.4
F · HF	160-260A / 22V-32V	160-280A / 24V-34V
VU · OH	140-230A / 22V-28V	150-240A / 22V-28V