

**Characteristics:**

LFC-811W2 is a titania type flux-cored wire. Use 100% CO₂ shield gas. With excellent mechanical property, good weldability, stable arc, less spatter and smooth bead appearance in all position welding.

Applications:

It is suitable for butt or fillet welding of 590 N/mm² weather –proof grade steel and ASTM A588, A242, A333 or COR-TEN 60 (used normally without painting)

Notes on Usage:

1. Use DC(+) polarity.
2. Use 100% CO₂ shielding gas.
3. Proper heat input can obtain required impact value.
4. Preheat is required and interpass Temperature should be controlled around 50-150°C.

Typical chemical composition of weld metal (wt%)

C	Mn	Si	P	S	Ni	Cr	Cu
0.03	1.15	0.57	0.015	0.007	0.65	0.60	0.45

Typical mechanical properties of weld metal

YP N/mm ²	TS N/mm ²	EL %	IV -30°C J
550	620	24	59

Welding Position**Sizes and recommended current range (DC <+>)**

Diameter (mm)	1.2 mm	1.6 mm
Parameters		
Voltage(Volt)	25-40	25-40
Current(Amp)	130-300	200-400
Stick out(mm)	15-25	15-25
Flow rate(l/min)	15-25	15-25
Weight per spool (kg)	15	15