

Applications

Oil and gas industry, Offshore industry, Power plant Petro chemical industry and oil pipes.

Characteristics on Usage

- ① As ST-1N contains 1% Ni, its impact value in low temperature is good.
- ② Both its bead appearance and weldability are excellent.
- ③ ST-1N is designed for welding of back bead of pipes.
- ④ ST-1N meets NACE Standard.

Shielding Gas | Welding Current

Ar GTAW: DC-

Typical Chemical Composition of Wire (%)

C	Si	Mn	P	S	Ni	Cu
0.082	0.62	1.15	0.011	0.010	0.87	0.08

Typical Mechanical Properties of All-Weld Metal

PWHT	YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J(ft.lbs) -45°C (-49°F)
As Weld	594 (86,000)	671 (97,300)	32.3	59 (43)
PWHT	568 (82,400)	645 (93,500)	34.0	108 (80)

Approval | Packing

ABS, CWB Size mm (in) 2.0 (5/64) 2.4 (3/32) 3.2(1/8)
 Weight 5kg* 900mm