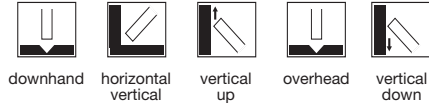


Guide to Using Your Murex Consumables Catalogue

Welding Symbols

The following symbols are intended as a guide only.



Recommended welding positions are printed in black. Acceptable positions are printed in grey.



All Weld Mechanical Properties

The mechanical properties of the deposited weld metal shown in this catalogue refer to all weld metal properties when deposited in the flat position. These may have little relevance to the properties of a real joint achieved in practice, since this will depend on the dilution from the base material, welding position, bead sequence and heat input. Apart from their use for quality control purposes, the mechanical properties of the all weld metal test provide the designer with an initial guide to the selection of welding consumables.

This is particularly important with regard to Charpy impact grading. Thus, consumables which have the highest grade are more likely to offer better Charpy properties when used in practice. They will not necessarily give the same level of Charpy results in a welded joint as they do in an all weld metal test piece.

Shielding Gases

For optimum performance of gas shielded wire, careful control of electrode extension (stickout) and of shielding gas flow rate are recommended in order to avoid nitrogen entrapment from the air. The use of low nitrogen shielding gas is also recommended. Consult your gas supplier for information on the nitrogen levels of shielding gas.