



**Chandraprabhu Enterprise Private Limited**

**LOW ALLOY WELDING WIRES**

**Name: CEPL-309 AWS A 5.29 E90 T5-K2**

Weld metal chemistry (with CO2 shield)	C = 0.10% Max, Mn = 0.80 to 1.50%, P = 0.03% Max, Si = 0.60% Max, S = 0.03%, Ni = 1.20–1.70%, Mo = 0.35% Max, Cr = 0.15% Max		
Typical all weld mechanical properties (with CO2 shield)	UTS = 660N/mm <sup>2</sup> Min; YS = 580N/mm <sup>2</sup> Min; Elongation(%) = 20% min. Typical charpyVnotch Impact value at -51°C = 40 J Min		
Welding parameter guidelines (with CO2 shield)	Size	Range	Recommended
	1.20mm	90–300A, 18–28V	180–300A, 22–26V
	1.60mm	125–400A, 18–30V	220–350A, 25–30V

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