



Chandraprabhu Enterprise Private Limited

LOW ALLOY WELDING WIRES

Name: CEPL-400 AWS A 5.29 E90 T5-K4

Weld metal chemistry (with CO2 shield)	C = 0.10% Max, Mn = 1.30 to 2.00%, P = 0.03% Max, Si = 0.60% Max, S = 0.03%, Ni = 1.75–2.50%, Mo = 0.30–0.60%, Cr = 0.25–0.60%		
Typical all weld mechanical properties (with CO2 shield)	UTS = 790N/mm2 Min; YS = 700N/mm2 Min; Elongation(%) = 18% 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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