GENERAL RECOMMENDATION

Recommended gas mixture is 98% Ar and 2% CO2.

PREHEATING
Swebor Armor™ 600 material shall be preheated to temperature not more than 100°C. Preheating is applied for hydrogen content control (expulsion of moisture).

INTERPASS TEMPERATURE
Interpass temperature for Swebor Armor™ 600 should not exceed 150°C. Backstep welding principle should be used for proper interpass temperatures.

HYDROGEN CONTENT
The hydrogen content shall be maximum 3 ml / 100 g of weld. Hydrogen content must be limited with proper preheating and proper use of consumables.

FOR MORE INFORMATION
Please check SWEBOR WELDING - WELDING RECOMMENDATION - DATASHEET