



GENERAL RECOMMENDATION

For welding of Swebor Armor™ 600 Swebor Stal recommends austenitic consumables (recommendation AWS307 - ER 307 - EN 1600: E 18 8 Mn R 12 - DIN 8556 : E 18 8 Mn R 26 - AWS A-5.4: E 307-17 - EN ISO 3581-A: E 18 8 Mn R 12 - W.Nr.: 1.4370) with low strength - undermatching principle must be applied for welding of Swebor Armor™ 600 grades.

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