

Classifications

EN ISO 17632-A	AWS A5.20
T46 Z Y N 1	E71T-11

Characteristics and typical fields of application

Self-shielded seamless flux cored wire designed for all positions welding of low and medium alloyed steels. This wire is especially useful for on-site fabrication, structural or repair welding applications, single or multipass welding. Main features: excellent weldability, also vertical-up, excellent bead appearance, low spatter levels and easily removable slag. The copper coated surface provides high resistance to rust and the seamless technology grants low moisture pick-up with low content of diffusible hydrogen levels (<H8).

Base materials

EN 10207: P253S - P265S - P275SL, EN 10025-2: S235JR - S275JR - S355JR, EN 10025-3: S275N - S355N - S420N - S460N, EN 10025-4: S275M - S355M - S420M - S460M, EN 10028-2: P235GH - P265GH - P295GH - P355GH
 EN 10028-3: P275NH - P355NH - P460NH, EN 10028-6: P355QH - P460QH, EN 10208-1: L210GA - L235GA - L245GA - L290GA - L360GA - (X42) - (X52), EN 10208-2: L245NB - L245MB - L290NB - L290MB - (X42) - L360NB - L360QB - L360MB - (X52) - L415NB - L415QB - L415MB - (X60) - L450QB - L450MB - (X65)

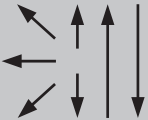
Typical analysis of all-weld metal (wt.-%)

C	Mn	Si	P	S	GAS
0.25	1.00	0,40	< 0,025	< 0,025	-

Mechanical properties of all-weld metal – typical values (minimum values)

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	-	-
	460	530	22	-	-

Operating data

	Ø (mm)	Current A	Voltage V
	0.80	30 - 110	13 - 16
	0.90	30 - 120	14 - 17
	1.00	50 - 200	15 - 18
	1.20	100 - 260	18 - 26
	1.40	120 - 300	20 - 27
	1.60	150 - 350	20 - 30
	2.00	300 - 450	20 - 44