

Classifications			
EN ISO 17632-A	EN ISO 17632-B	AWS A5.20	AWS A5.20M
T46 4 P M 1 H5	T555T1-1MA-H5	E71T-1M-JH4	E491T-1M-JH4
T46 2 P C 1 H5	T553T1-1CA-H5	E71T-1C-H4	E491T-1C-H4

Characteristics and typical fields of application

Seamless rutile flux cored wire for single or multipass welding of Carbon, Carbon-Manganese steels and similar types of steels including fine grain ones with Argon-CO₂ shielding gas or pure CO₂. Main features: excellent weldability in all positions, no spatter, fast freezing and easy to remove slag and bead is smooth and bright. Excellent performance and welding speed. This wire is especially suitable for ship building, steel structural work or wherever good bead appearance is required.

Base materials

EN 10207: P253S - P265S - P275SL, **EN 10025-2:** S235JR-J0-J2 - S275JR-J0-J2 - S355JR-J0-J2-K2 - S450J0, **EN 10025-3:** S275N - S275NL - S355N - S355NL - S420N - S420NL - S460N, **EN 10025-4:** S275M - S275ML - S355M - S420M - S460M, **EN 10028-2:** P253GH - P265GH - P295GH - P355GH, **EN 10028-3:** P275NH - P355NH - P460NH - P355N, **EN 10028-6:** P355QH - P460QH - P355Q - P460Q, **EN 10028-5:** P355M - P490M - P460M, **EN 10208-1:** L210GA - L235GA - L245GA - L290GA - (X42) - L360GA - (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.-%)

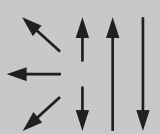
C	Mn	Si	P	S	GAS
0.06	1.30	0.45	< 0.025	< 0.025	M21
0.04	1.00	0.40	< 0.025	< 0.025	C1

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

Shielding gas	Heat-treatment	Yield strength	Tensile strength	Elongation	Impact work in J CV		
		R _{p0.2}	R _m	A (L ₀ =5d ₀)	-20°C	-40°C	-50°C
		MPa	MPa	%			
M21	AW	460	530	22	100	80	47
C1	AW	420	420	22	47	-	-

Untreated, as welded – shielding gas Ar + 18% CO₂

Operating data

	Ø (mm)	Wire feed m/min	Weight (Kg)	Current A	Voltage V
	1.00	B300	16	160 - 270	21 - 34
	1.20	B300	16	190 - 320	22 - 35
	1.40	B300	16	200 - 350	23 - 36
	1.60	B300	16	210 - 380	23 - 37

Other spool types on request.

Approvals

RINA • TÜV (00219) • LR • ABS • DNV • BV • GL • DB (42.052.03) • RS