

VENVU ARS 15

FCAW - Flux-Cored Wire



Classifications							
EN ISO 18276-A	EN ISO 18276-B	AWS A5.29		AWS A5.29M			
T69 6 Z P M 1 H5	T766T1-1MA-G-UH5	E111T1-GM-JH4		E761T1-GM-JH4			
Characteristics and typical fields of application							
Seamless rutile, Nickel-Molybdenum alloyed, flux cored wire for single or multipass welding of high strength steels such as T1 and WELDOX 700 with Argon-CO ₂ shielding gas. Main features: excellent weldability in all positions, excellent bead appearance, no spatter and fast freezing and easy to remove slag. The exceptional mechanical properties of this wire even at the lowest temperatures (-40°C) as well as the low content of diffusible Hydrogen make it especially suitable for off-shore and pipeline applications.							
Base materials							
EN 10028-6: P690QH - P500Q - P690Q - P500QL1 - P690QL1, EN 10025-6: S550Q - S620Q - S690Q - S650QL - S620QL - S690QL, EN 10208-2: L555QB - L555MB - (X80)							
Typical analysis of all-weld metal (wt.-%)							
C	Mn	Si	P	S	Ni	Mo	GAS
0.07	1.70	0.40	< 0.020	< 0.020	2.00	0.18	M21
Mechanical properties of all-weld metal – typical values (minimum values)							
Condition	Heat-treatment	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work in J CVN		
		MPa	MPa	%	-40°C	-60°C	
u	AW	690	770	17	69	60	
u: untreated, as welded – shielding gas Ar + 18% CO ₂							
Operating data							
	Ø (mm)	Spool	Weight (Kg)	Current A	Voltage V		
	1.00	B300	16	160 - 270	21 - 33		
	1.20	B300	16	160 - 320	22 - 34		
	1.40	B300	16	200 - 350	23 - 35		
	1.60	B300	16	210 - 380	23 - 36		
Other spool types on request.							
Approvals							
ABS • BV • DNV • LR • GL							