

CLASSIFICATIONS

EN ISO 17632-A : T 46 2 P M 1

AWS A5.20 : E71 T-1M

DESCRIPTION

- Rutile type flux cored wire which is used for the production welding of machine and welding applications on ship, and steel constructions in all positions. Provides high mechanical properties, proper, smooth, X-ray safety seams
- It is economical as it has high melting ability and can work with high current in all positions.
- Shielding Gas: M21 (CO₂)

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.06 | Si: 0.5 | Mn: 1.3

MECHANICAL PROPERTIES

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-20°C)	Elongation (L ₀ =5d ₀) (%)
AW	min. 460	530- 600	min. 50 J	min. 22

AW: as welded

BASE MATERIALS

- S235JR, S275JR, S235J2G3- S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L360NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JR51-S235J45, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

WELDING POSITIONS



CURRENT CONDITION

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
2010300008	1.20	0.047"	15	BS 300