

CLASSIFICATIONS

EN ISO 17632-A : T 42 4 P C 1 H5

AWS A5.20 : E 71T-1C-J

DESCRIPTION

- Rutile type flux-cored wire which is used for the production welding of machine and welding applications on ship, industry vehicle building 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 under high current in all positions
- Shielding gas : %100 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/-40°C)	Elongation (L ₀ =5d ₀) (%)
AW	min. 420	500- 640	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, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NLGE200-GE260

WELDING POSITIONS



CURRENT CONDITION

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
2010300001	1.20	0.047"	4.5	D 200
2010300005	1.20	0.047"	15	D 300
2010300006	1.20	0.047"	15	BS 300
2010300002	1.60	0.062"	15	BS 300
2010300007	1.60	0.047"	200	DRUM PACK