

CLASSIFICATIONS

EN ISO 17632-A : T 42 4 B M 3 H5

AWS A5.20 : E70T-5M J

DESCRIPTION

- Used for semi-automatic or fully automatic welding of alloyed or unalloyed construction steels, thin-walled steels
- It has soft arc, deep penetration, good bead features
- Impact strength values are higher than those of E71 T-1 in at low temperatures
- M21 gas is used for shielding

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.05 | Si: 0.55 | Mn: 1.35

MECHANICAL PROPERTIES

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength		Elongation (L ₀ =5d ₀) (%)
			(ISO-V/-30°C) (with M21 gas)	(ISO-V/-40°C) (with CO ₂ gas)	
AW or A	min. 420	520 - 670	120 J	min. 47 J	min. 22

AW: as welded A: aging

BASE MATERIALS

- EN: S185, S235-S355, P 235 GH, P 265 GH, P 295 GH, P 235 T1/T2-P355N, I2 10-L485, S 255-S460, X42-X70
 ASTM: A 131, A106/A515/A 714, A283/A285/A414/A662/A372, A369/A210/ A106, A516/A255/A 333/ A350/

WELDING POSITIONS



CURRENT CONDITION

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
2010300003	1.20	0.047"	15	BS 300
2010300004	1.60	0.062"	15	BS 300