

CLASSIFICATIONS

EN ISO 17632-A : T 46 5 M M 3

AWS A5.18 : E 70 C-6 M

DESCRIPTION

- Suitable for butt and fillet welding. Better arc stability and wider optimum current range for spray transfer arc with less spattering than solid wire
- Shielding gas M21

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.05 | Si: 0.65 | Mn: 1.60

MECHANICAL PROPERTIES

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-50°C)	Elongation (L ₀ =5d ₀) (%)
AW	min. 460	530 - 650	min. 47 J	min. 22

AW: as welded

BASE MATERIALS

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L415NB, L290MB-L415MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JR51-S235J4S, S315G1S-S355G3S, S255N-S420N, S255NL-S355NL, GE200-GE260, X42-X60

WELDING POSITIONS



CURRENT CONDITION

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
2010300011	1.20	0.047"	15	BS 300
2010300012	1.60	0.062"	15	BS 300