

CLASSIFICATIONS

EN ISO 17632-A : T 50 4 M M 3

AWS A5.28 : E 80 C Ni 1

DESCRIPTION

- Suitable for automation welding applications
- It is metal cored wire
- It has soft arc, deep penetration, good bead features
- Suitable for butt and fillet welding
- Shielding gases: M21 (Ar+%5-25CO₂)

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.05 | Si: 0.50 | Mn: 1.20 | Ni: 1.00

MECHANICAL PROPERTIES

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength (ISO-V/-45°C)	Elongation (L ₀ =5d ₀) (%)
AW	min. 500	560 - 720	min. 47 J	min. 24

AW: as welded

WELDING POSITIONS



CURRENT CONDITION

FCAW / D.C. (+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (kg)	Package Type
2010300013	1.20	0.047"	15	BS 300
2010300014	1.40	0.055"	15	BS 300
2010300015	1.40	0.055"	200	DRUM PACK