

CLASSIFICATIONS

EN ISO 17632-B : T 46 3 Z P C 1

AWS A5.29 : E 81 T1-W2 C

DESCRIPTION

- Rutile flux-cored wire
- Typical application is weathering grades of steels
- Excellent weld puddle manipulation, superior all-position welding
- Particularly suited for mechanized MAG welding and all-position welding on ceramic backing
- Low spatter with easy slag removal
- Shielding Gas: CO₂

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.05 | Si: 0.5 | Mn: 1.3 | Ni: 0.5 | Cr: 0.55 | Cu: 0.50

MECHANICAL PROPERTIES (With M21 gas)

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength		Elongation (L ₀ =5d ₀) (%)
			(ISO-V/-20°C)	(ISO-V/-30°C)	
AW	min. 460	550 - 690	min. 60J	min. 47 J	min. 19

AW: as welded

BASE MATERIALS

- DIN: COR-TEN A-B-C
- EN: S235JRW-S355JRW, 9CrNiCuP3-2-4, S255-S460,
- ASTM: A 242/A441, A423/ A 588, A516/ A 255/ A 333/ A 350 / A612

WELDING POSITIONS



CURRENT CONDITION

D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
2010300019	1.20	0.047"	15	BS 300