

CLASSIFICATIONS

EN ISO 17632-A : T 46 4 1Ni P C 1

AWS A5.29 : E81 T1-Ni1 C

DESCRIPTION

- Rutile type flux cored welding wire with good toughness in mild and 490-550 MPa high tensile steels at low service temperatures
- Suitable for butt and fillet welding in all positions
- You can get smooth arc, and low spatter, good weldability
- Shielding Gas: CO₂

CHEMICAL ANALYSIS OF WELD METAL % (TYPICAL)

C: 0.05 | Si: 0.5 | Mn: 1.30 | Ni: 0.90

MECHANICAL PROPERTIES (With CO₂ gas)

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Impact Strength		Elongation (L ₀ =5d ₀) (%)
			(ISO-V/-40°C)	(ISO-V/-30°C)	
AW	min. 460	560 - 690	50 J	80 J	min. 24

AW: as welded

BASE MATERIALS

- EN: S 185, S235-S355, P 235 GH, P 265 GH, P 295 GH, P 235 T1/T1-P 355 N, L210-L485, S255-S500 (NL1,2), X 42-X80
- ASTM: A 131, A 106/A515/A714, A 283/A285/A414/A662/A372, A369/A210/A106/A516/A573/A707, A516/A255/ A299/ A333/ A350/ A612

WELDING POSITIONS



CURRENT CONDITION

FCAW / D.C.(+)

OPERATING DATA

Product Code	Diameter x Length (mm) / (inch)		Weight (Kg)	Package Type
2010300016	1.20	0.047"	15	BS 300