

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.36/SFA-5.36	AWS A5.36M/SFA-5.36M
T42 Z Y NO 1 H10	T49T11-1NO-H10	E71T11-AZ-CS3-H8	E491T11-AZ-CS3-H8

Characteristics and typical fields of application

Self-shielded seamless flux cored wire designed for all position welding of low and medium alloyed steels. This wire is especially useful for on-site fabrication, structural or repair welding applications, single or multipass welding.

Main features: good weldability, also vertical-up Position, good bead appearance, low spatter levels and easy to remove slag. The copper coated surface provides high resistance to rust and the seamless technology grants low moisture pick-up with low content of diffusible hydrogen levels (< H8).

Base materials

S235JR-S355JR, P355N, P195TR1-P265TR1, L210GA-L360 GA, L245NB-L415NB, L450QB, L245MB-L450MB

ASTM A 106 Gr. A, B; A 181 Gr. 60; A 283 Gr. A; A 285 Gr. A, B; A 414 Gr. A, B; A 501 Gr. B; A 516 Gr. 55, 60; A 573 Gr. 55, 58; A 588 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65

Typical analysis of all-weld metal (wt.-%)

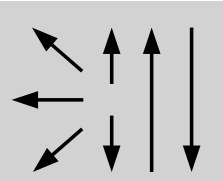
	Gas	C	Si	Mn	Al
wt-%	-	0.25	0.40	1.00	1.50

Mechanical properties of all-weld metal

Condition	Yield strength R_e	Tensile strength R_m	Elongation A ($L_0=5d_0$)
	MPa	MPa	%
u	440 (≥ 420)	600 (500–640)	22 (≥ 20)

u untreated, as welded

Operating data

	Polarity: DC (–)	ø (mm)
		1.0
		1.2
		1.4
		1.6

Welding with standard GMAW power source possible

Approvals

CE