

CATEGORY FCAW Flux-Cored

TYPE Rutile fluxcored wire with exceptional toughness down to -60°C

APPLICATIONS Steel construction, shipbuilding, pressure vessels, mechanical engineering, pipe work, offshore, crane building, heavy transport etc..

PROPERTIES Seamless rutile flux cored wire with excellent welding properties combined with extreme impact toughness down to -60°C. Fast freezing slag for economic welding in PF position up to 280 ampere without any spatters. Due to the seamless production process this wire is strongly recommended for atomized welding such as with robots. Due to the seamless production process the hydrogen content is below 3ml/100g weld metal even after long storage.

CLASSIFICATION	AWS	A 5.20: E71T-1C-J H4
	AWS	A 5.20: E71T-1M-J H4
	AWS	A 5.36: E71T1-1CA0-CS1-H4
	AWS	A 5.36: E71T1-M21A8-CS1-H4
	AWS	A 5.36: E71T1-1CA4-CS1-H4
	EN ISO	17632-A: T 46 6 P M21 1 H5
	EN ISO	17632-A: T 46 4 P C1 1 H5
	F-nr	6
FM	1	

SUITABLE FOR **Reh ≤ 460 MPa (67 ksi) ISO 15608: 1.2, 1.3, 2.1**
 1.5637, 1.6217, 1.6228, 1.0044-1.09821.0035 - 1.0570, 1.0345, 1.0425, 1.0481, 1.0308 - 1.0581, 1.0307 - 1.0582, 1.0440, 1.0472, 1.0475, 1.0416 to 1.0551
 10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6,
 S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240, A, B, D, E, A 32-E 36
 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65
 Domex 315-460MC, MC Plus, ML

APPROVALS TÜV (19710) CE



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Ni
0.08	0.5	1.3	0.4

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2}	R _m	A ₅	Impact Energy (J) ISO-V	
As Welded /	MPa	MPa	(%)	-40°C	-60°C
	490	590	24	60	55

WELDING PARAMETERS / PACKING

PARAMETERS	PARAMETERS	PARAMETERS	PACKING	PACKING	PACKING
D (MM)	VOLTAGE V	CURRENT A (DC+)	SPOOLING TYPE	KG / SPOOL / DRUM	KG / PALLET
1,0	19-25	140-230	D-200 / K-300 / DRUM	5 / 16 / 600	1200 - 1024 - 600
1,2	21-29	160-280	D-200 / K-300 / DRUM	5 / 16 / 600	1200 - 1024 - 600
1,6	23-32	190-350	D-200 / K-300 / DRUM	5 / 16 / 600	1200 - 1024 - 600

REDRYING TEMPERATURE Not required

