

CATEGORY	Oxi-Acetylene welding		
TYPE	Copper-coated filler metal for gas welding (0,5% Ni)		
APPLICATIONS	Gas welding of steels that require good impact properties at low temperature.		
PROPERTIES	Excellent impact properties at low temperatures due to the addition of Nickel with increased yield strength.		
CLASSIFICATION	AWS	A 5.2: R60	
	EN ISO	20378: O III	
	F-nr	6	
	FM	1	
SUITABLE FOR	Steels up to a yield strength of 275MPa (40 ksi). S185-E295, S235JR-S275JR ASTM: A36, A106 grades A/B/C, A139 grade A, A210 grades A1/C, A216 grades WCA/WCB/WCC, A234 grade WPB		
APPROVALS	CE		

WELDING POSITIONS:



TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)

C	Si	Mn	Ni
0.1	0.1	1.1	0.4

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2}	R _m	A ₅	Impact Energy (J) ISO-V
As Welded /	MPa	MPa	(%)	RT
	340	470	20	65

WELDING PARAMETERS / PACKING

SIZES		SIZES	WELDING PARAMETERS	PACKING	PACKING
D (MM)	LENGTH (MM)		FLAME TYPE	KG / PACKAGE	KG / PACK
2.0	1000		NEUTRAL TO REDUCING	5	25
3.2	1000		NEUTRAL TO REDUCING	5	25
4.0	1000		NEUTRAL TO REDUCING	5	25

REDRYING TEMPERATURE	Not required
GAS ACCORDING EN 14175	None