

Standards

EN ISO17632-A: T42 0 Z W NO 1
AWS A5.20: E71T - 11

Chemical Composition of Weld Metal (Typical)

C	Mn	Si	P	S
0.13	0.76	0.10	0.012	0.003
Al	Ni	Mo	Cr	V
1.6	0.08	0.005	0.04	0.003

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Elongation ((L ₀ =5d ₀) (%))
min 390	490-670	not specified	≥20

Features and Applications

- Self-shielding flux cored wire
- Suitable for welding of low carbon and mild steels where impact strength is not required
- Easy slag removal, low spatter
- Shielding gas: Open Arc
- They are general purpose electrodes for single and multiple pass welding in all positions.
- Their use is generally not recommended on thicknesses greater than [19 mm].

Welding Positions

Current Type

FCAW / D.C. (-)

Operating Data

Product Code	Diameter (mm)	Weight (Kg)	Package Type
6011100415	1.20	15	D270
6011100591	0.8	5	D200
6011100592	1.0	5	D200
6011100593	1.2	5	D200