

Standards

EN ISO 18276-A	: T 89 4 Mn2NiCrMo B M 3 H5
EN ISO 18276-B	: T 83 4 T5 0M N4C1M2 H5
AWS ASME 5.29	: E120 T5-K4M H4
AWS ASME 5.29 M	: E760T5-K4M H4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	P	S	Cr	Ni	Mo
0.05	0.4	1.6	<0.015	<0.015	0.6	1.8	0.5

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-20°C)	Impact Strength (ISO-V/-50°C)	Elongation ((L ₀ =5d ₀) (%))
PWHT	min. 890	940-1180	min. 60 J	min. 47 J	min. 15

PWHT: 250°C / 2 hours post-weld heat treatment

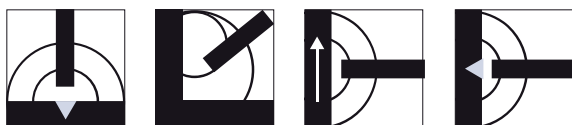
Typical Base Material Grades

- EN: S890QL1, S960QL1
- ASTM: A517, X120

Features and Applications

- High-basicty seamless copper coated flux-cored wire designed for Ar–CO₂ gas mixtures.
- Used for welding fine-grain steels, high yield strength and austempered steels in lifting and handling equipment, crane fabrication, bridge construction, shipbuilding, railway and mining industries.
- Weld metal exhibits excellent resistance to cracking due to its very low hydrogen content.
- Offers low spatter characteristics.

Welding Positions



Current Type

FCAW / D.C. (+)

Packaging Details

Diameter (mm) / (inch)		Weight (Kg)	Spool Type
1.20	0.047"	15	BS300