Standards

EN ISO 18276-A	: T 89 4 Mn2NiCrMo M M 1 H5
EN ISO 18276-B	: T 83 4 T15 1M N4C1M2 H5
AWS ASME 5.28	: E120C-K4 H4
AWS ASME 5.28 M	: E83C-K4 H4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	P	S	Cr	Ni	Mo
0.07	0.5	1.5	<0.015	<0.015	0.6	2.5	0.6

Mechanical Properties

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-20°C)	Impact Strength (ISO-V/-40°C)	Elongation ($(L_o=5d_o)$ (%)
PWHT	min. 920	940-1030	min. 55 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

- Slag-free seamless copper coated metal-cored wire designed for Ar–CO_2 shielding gas mixtures.
- Suitable for welding fine-grain high-strength steels in applications such as cranes, pressure vessels, and steel structures.
- Offers reliable and smooth arc ignition.
- Well-suited for robotic and multi-pass welding applications.

Welding Positions

Current Type

FCAW / D.C. (+)

Packaging Details

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