

### Standards

|                   |                   |
|-------------------|-------------------|
| TS EN ISO 17632-A | : T 46 4 M M 1 H5 |
| EN ISO 17632-A    | : T 46 4 M M 1 H5 |
| AWS A5.18         | : E70C-6M H4      |

### Chemical Composition of Weld Metal (Typical)

| C    | Si  | Mn  | P     | S     |
|------|-----|-----|-------|-------|
| 0.05 | 0.7 | 1.5 | 0.015 | 0.015 |

**Approvals:** ABS, BV, DNV, TL

### Mechanical Properties

| Heat Treatment | Yield Strength<br>(N/mm <sup>2</sup> ) | Tensile Strength<br>(N/mm <sup>2</sup> ) | Impact Strength |               | Elongation<br>((L <sub>0</sub> =5d <sub>0</sub> ) (%)) |
|----------------|----------------------------------------|------------------------------------------|-----------------|---------------|--------------------------------------------------------|
|                |                                        |                                          | (ISO-V/-30°C)   | (ISO-V/-40°C) |                                                        |
| PWHT           | min. 500                               | 580-680                                  | min. 120 J      | min. 100 J    | min. 22                                                |

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

### Typical Base Material Grades

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L415NB, L290MB-L415MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S420N, S255NL-S355NL, GE200-GE260, X42-X70

### Features and Applications

- Seamless, copper-coated metal-cored welding wire, suitable for butt and fillet weld joints.
- Generates less spatter compared to solid wires and allows a wider range of current settings in spray arc mode.
- Offers a high metal deposition rate.
- Provides better arc stability than solid wires.
- Weld metal contains very low diffusible hydrogen.

### Welding Positions



### Current Type

FCAW / D.C. (+)

### Packaging Details

| Diameter<br>(mm) / (inch) |        | Weight<br>(Kg) | Spool Type |
|---------------------------|--------|----------------|------------|
| 1.20                      | 0.047" | 15             | BS300      |