

Standards

TS EN ISO 17632-A	: T 46 4 P C1 H5 / T46 4 P M1 H5
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AWS A5.20	: E71 T-1C/-1M H4

Chemical Composition of Weld Metal (Typical)

C	Si	Mn
0.05	0.5	1.3

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength		Elongation ((L ₀ =5d ₀) (%))
			(ISO-V/-20°C) (with M21 gas)	(ISO-V/-40°C) (with CO ₂ gas)	
AW	min. 460	530-680	min. 75 J	min. 60 J	min. 22

AW: as welded

Typical Base Material Grades

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L360NB, L290MB L415MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

Features and Applications

- Rutile type seamless copper coated flux cored wire which is used for the welding of machinery and welding applications on ship, and steel constructions in all positions.
- Provides high mechanical properties, proper, smooth, X-ray safety seams.
- It is economical as it has high melting ability and can work with high current in all positions.
- Shielding Gas: CO₂ or M21

Welding Positions



Current Type

FCAW / D.C. (+)

Packaging Details

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