

Standards

EN ISO 17632-A : T 50 6 1Ni P M 1 H5 / T 46 4 1Ni P C 1 H5
AWS 5.29 : E 81T1-Ni1C, Ni1M J H4

Chemical Composition of Weld Metal (Typical)

C	Mn	Si	Ni
0.05	1.3	0.50	0.9

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Impact Strength (ISO-V/-60°C)	Elongation ((L ₀ =5d ₀) (%))
PWHT	500	580-680	min. 90 J	min. 60 J	min. 22

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

Typical Base Material Grades

- EN: S 185, S235-S355, P 235 GH, P 265 GH, P 295 GH, P 235 T1/T1-P 355 N, L210-L485, S255-S500(NL1,2), X 42-X80 ASTM: A131, A106/A515/A714, A 283/A285/A414/A662/A372, A369/A210/A106/A516/A573/ A707, A516/A255/ A299/ A333/ A350/ A612

Features and Applications

- Seamless rutile-type copper coated flux-cored wire with microalloying elements and fast-freezing slag, designed for use with 100% CO₂ or Ar-CO₂ shielding gas mixtures.
- Provides excellent weld pool control for smooth operation.
- Suitable for all-position welding and low-temperature applications down to -60 °C.
- Especially well-suited for use with ceramic backing and MAG orbital welding.
- Offers low spatter, easy slag removal.
- Weld metal hydrogen content remains unaffected during wire storage.
- Shielding Gas: CO₂ or M21.

Welding Positions



Current Type

FCAW / DC (+)

Packaging Details

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