

**Standards**

TS EN ISO 17632-A	: T 46 4 P C1 H5 / T46 3 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 <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength		Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
			(ISO-V/-30°C) (with M21 gas)	(ISO-V/-40°C) (with CO <sub>2</sub> gas)	
AW	min. 460	530-680	min. 47 J	min. 47 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 flux cored wire which is used for the production welding of machine 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: CO<sub>2</sub> or M21

**Welding Positions**

**Current Type**

FCAW / D.C. (+)

**Operating Data**

Diameter (mm) / (inch)		Weight (Kg)	Package Type
1.20	0.047"	15	D 300