



Standards

TS EN ISO 17632-A : T 46 4 P C1 H5 / T46 3 P M1 H5 FN ISO 17632-A : T 46 4 P C1 H5 / T46 3 P M1 H5 AWS A5 20 · F71 T-1C/-1M H4

Chemical Composition of Weld Metal (Typical)

С	Si	Mn
0.05	0.5	1.3

Mechanical Properties

Heat Treatment	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Impact S (ISO-V/-30°C) (with M21 gas)	(ISO-V/-40°C)	Elongation ((Lo=5do) (%)
AW	min. 460	530-680	min. 47 J	min. 47 J	min. 22

AW: as welded

Typical Base Material Grades

 \$235JR, \$275JR, \$235J2G3-\$355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L360NB. L290MB L415MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S. S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

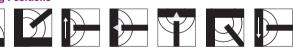
Features and Applications

 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: CO₂ or M21

Welding Positions















Current Type

FCAW / D.C. (+)

Operating Data

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