

Standards

TS EN ISO 17632-A	: T 42 4 B M 3 H5
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AWS A5.20	: E70T-5M J

**Chemical Composition of
Weld Metal (Typical)**

C	Si	Mn
0.05	0.55	1.35

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength		Elongation (L ₀ =5d ₀) (%)
			(ISO-V/-30°C)	(ISO-V/-40°C)	
AW or A	min. 420	520 - 670	120 J	min. 47 J	min. 22

AW: as welded A: aging

Typical Base Material Grades

- EN: S185, S235-S355, P 235 GH, P 265 GH, P 295 GH, P 235 T1/T2-P355N, I2 10-L485, S 255-S460, X42-X70
 ASTM: A 131, A106/A515/A 714, A283/A285/A414/A662/A372, A369/A210/A106, A516/A255/A 333/ A350/

Features and Applications

- Used for semi-automatic or fully automatic welding of alloyed or unalloyed construction steels, thin-walled steels
- it has soft arc, deep penetration, good bead features
- Impact strength values are higher than those of E71 T-1 in at low temperatures
- M21 gas is used for shielding

Welding Positions

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500141	1.20	0.047"	15	BS 300
3010500143	1.60	0.062"	15	BS 300

Approvals: CE, SEPRO