

Standards

TS EN ISO 17632-A	: T 46 4 M M 3
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AWS A5.18	: E 70 C-6 M

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

C	Si	Mn
0.05	0.65	1.60

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Elongation ((L ₀ =5d ₀) (%))
AW	min. 460	530- 650	min. 47 J	min. 22

AW: as welded

Typical Base Material Grades

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L415NB, L290MB-L415MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S420N, S255NL-S355NL, GE200-GE260, X42-X60

Features and Applications

- Suitable for butt and fillet welding. Better arc stability and wider optimum current range for spray transfer arc with less spattering than solid wire
- Shielding gas M21

Welding Positions

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500249	1.20	0.047"	15	BS 300
3010500251	1.60	0.062"	15	BS 300

Approvals: ELCOR M 70 (M21): BV, ABS, CE, SEPRO