

Standards

TS EN ISO 17632-A	: T 50 4 M M 3
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AWS A5.28	: E 80 C Ni 1

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Ni
0.05	0.50	1.20	1.00

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-45°C)	Elongation ((L ₀ =5d ₀) (%))
AW	min. 500	560 - 720	min. 47 J	min. 24

AW: as welded

Features and Applications

- Suitable for automation welding applications
- It is metal cored wire
- It has soft arc, deep penetration, good bead features
- Suitable for butt and fillet welding
- Shielding gases: M21 (Ar+%5-25CO₂)

Welding Positions



Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500331	1.20	0.047"	15	BS 300
3010500332	1.40	0.055"	15	BS 300
3010500335	1.40	0.055"	200	BIG PACK

Approvals: CE, SEPRO