

Standards

TS EN ISO 17632-A	: T 42 4 R C3 H10
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AWS A5.20	: E 70 T-9 C J H 8

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

C	Si	Mn
0.04	0.70	1.40

Mechanical Properties

Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-40°C)	Elongation ((L ₀ =5d ₀) (%))
min. 420	500- 640	min. 47 J	min. 22

Features and Applications

- Metal-Rutile type flux cored welding wire
- High fill rate and deep penetration
- Suitability flat and horizontal fillet weld
- Excellent notch toughness value at low temperatures.
- Shielding Gas: CO₂

Welding Positions

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500122	1.20	0.047"	15	BS 300

Approvals: CE, SEPRO