Standards

TS EN ISO 18276-A	: T 69 4 Mn2.5Ni P C 1
EN ISO 18276-A	: T 69 4 Mn2.5Ni P C 1
AWS A5.29	: E 111 T1 - GC

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Ni	Mo
0.08	0.5	1.70	2.10	0.20

Mechanical Properties - (Typical): (With CO_2 gas)

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (ISO-V/-40°C)	Elongation (($L_o=5d_o$) (%)
AW	min. 690	770 - 940	min. 47 J	min. 17

AW: as welded

Typical Base Material Grades

- S690Q, L690M, N-A-XTRA, USS-T1, BH 70V, HY100,
- ASTM A514Gr.F
- High alloyed structural steels, fine grained steels.

Features and Applications

- Rutile type flux cored wire which provides an exceptionally smooth and stable arc, low spatter.
- Applications of single and multipass welding of high strengthlow alloy steels such as HY-80 and HY-100
- Shielding gas: CO_2

Welding Positions

Current Type

FCAW / D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500354	1.20	0.047”	15	BS 300

Approvals: ABS, SEPRO, TL, CE