

Standards

TS EN ISO 17632-A	: T 46 2 P M 1
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AWS A5.20	: E71 T-1M

Chemical Composition of Weld Metal (Typical)

C	Si	Mn
0.06	0.5	1.3

Mechanical Properties

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-20°C)	Elongation ((L ₀ =5d ₀) (%))
AW	min. 460	530- 600	min. 50 J	min. 22

AW: as welded

Typical Base Material Grades

- S235JR, S275JR, S235J2G3- S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L360NB, L290MB-L360MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

Features and Applications

- Rutile type flux cored wire which is used for the production welding of machine and welding applications on ship, and steel constructions in all positions. Provides high mechanical properties, proper, smooth, X-ray safety seams
- It is economical as it has high melting ability and can work with high current in all positions. Shielding Gas: M21 (CO₂)

Welding Positions



Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500112	1.20	0.047"	15	BS 300

Approvals: CE, SEPRO