

### Standards

TS EN ISO 17632-A	: T 46 4 P C 1 H5
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AWS A5.20	: E 71T-1C/-9C J

### Chemical Composition of Weld Metal (Typical)

C	Si	Mn
0.06	0.5	1.3

### Mechanical Properties

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-40°C)	Elongation (L <sub>0</sub> =5d <sub>0</sub> ) (%)
AW	min. 460	530 - 670	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-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, industry vehicle building 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 under high current in all positions
- Shielding gas: %100 CO<sub>2</sub>

### Welding Positions



### Current Type

FCAW / D.C. (+)

### Operating Data

Product Code	Diameter (mm)	Weight (Kg)	Package Type
3010500409	1.2	15	D 320