

Standards

TS EN ISO 17632-B	: T 55 3 T1-1CA-NCC1
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AWS A5.29	: E 81 T1-W2 C

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Ni	Cr	Cu
0.05	0.5	1.3	0.5	0.55	0.50

Mechanical Properties - (Typical)

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength (ISO-V/-30°C)	Elongation ((L ₀ =5d ₀) (%))
AW	min. 470	550 - 690	min. 47 J	min. 19

AW: as welded

Typical Base Material Grades

- DIN: COR-TEN A-B-C
- EN: S235JRW-S355JRW, 9CrNiCuP3-2-4, S255-S460,
- ASTM: A 242/A441, A423/ A 588, A516/ A 255/ A 333/ A 350 / A612

Features and Applications

- Rutile flux-cored wire
- Typical application is weathering grades of steels
- Excellent weld puddle manipulation, superior all-position welding
- Particularly suited for mechanized MAG welding and all-position welding on ceramic backing
- Low spatter with easy slag removal
- Shielding Gas: CO₂

Welding Positions



Current Type

D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500364	1.20	0.047"	15	BS 300

Approvals: CE, SEPRO