

Standards

TS EN ISO 18276-A	: T 62 4 Mn 1.5 Ni PC 1
EN ISO 18276-A	: T 62 4 Mn 1.5 Ni PC 1
AWS A5.29	: E91T1 - K2CJ

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

C	Si	Mn	Ni
0.08	0.5	1.20	1.70

Mechanical Properties - (Typical): (With CO₂ gas)

Heat Treatment	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Impact Strength		Elongation ((L ₀ =5d ₀) (%))
			(ISO-V/-20°C)	(ISO-V/-40°C)	
AW	min. 620	690 - 890	min. 62 J	min. 47 J	min. 18

AW: as welded

Typical Base Material Grades

- S380N-S500N, S355NH-S460NH, S380NL-500NL

Features and Applications

- Rutile type flux cored wire for 550-620 N/mm² high tensile strength steel for low temperature service
- Suitable for butt and fillet welding all positions
- Excellent impact value at low temperatures down to -40°C
- Shielding gas: CO₂

Welding Positions

Current Type

FCAW / D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500348	1.20	0.047"	15	D 300

Approvals: ABS, SEPRO, CE