Standards

TS EN ISO 17632-A	: T 46 2 Mo R C 2
EN ISO 17632-A	: T 46 2 Mo R C 2
AWS A5.29	: E 81 T1-A1C

Chemical Composition of Weld Metal (Typical)

C	Si	Mn	Mo
0.05	0.50	1.25	0.50

Mechanical Properties - % (Typical)

Heat Treatment	Yield Strength (N/mm^2)	Tensile Strength (N/mm^2)	Impact Strength (RT)	Impact Strength (ISO-V/-20°C)	Elongation ($(L_o=5d_o)$ (%)
AW	min.470	550 - 650	min.70 J	min.47 J	min.22
SR (620°C / 1h, air cooled at 300°C)	min.470	550 - 680	min.70 J	min.47 J	min.21

AW: as welded **SR:** stress relieved **RT:** room temperature

Typical Base Material Grades

- DIN: HI, HII, 17Mn4, 19Mn5, 15Mo3, 16 Mo 3
- EN: P 235 GH, P 265 GH, P 295 GH, 16 Mo 3, P 235 T1fT2-P355 N, L210-L485, S255-L485
- ASTM: A283, A285, A414, A662, A372, A204, A 369, A210, A106, A 516, A 255, A 333, A 350, A 612

Features and Applications

- Rutile type flux-cored wire
- Typical applications are vessel and steel construction, mechanical engineering and pipe work.
- Good arc restriking even with cold wire tip, suitable for robot applications
- Multi-pass welding without in-between cleaning
- Ideal for use in the field short arc and spray arc
- Excellent gap bridging for root welding
- High-effeciency type for economic production environments
- Shielding Gas: CO_2

Welding Positions

Current Type

D.C.(+)

Operating Data

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
3010500367	1.20	0.047”	15	BS 300

Approvals: CE, SEPRO