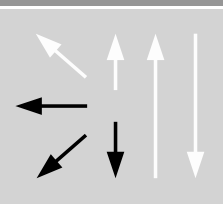


Classifications					
EN ISO 17632-A	EN ISO 17632-B	AWS A5.36		AWS A5.36M	
T42 4 B M 1 H5	T556T5-1MA-H5	E70T5-M21A4-CS1-H4		E490T5-M21A4-CS1-H4	
T42 4 B C 1 H5	T496T5-1CA-H5	E70T5-C1A4-CS1-H4		E490T5-C1A4-CS1-H4	
Characteristics and typical fields of application					
Seamless basic flux cored wire for single- or multilayer welding of Carbon, Carbon-Manganese steels and similar steels, including fine grain steels with Argon-CO ₂ shielding gas or pure CO ₂ . Main features: excellent weldability in flat and horizontal position, smooth and bright bead, very low spatter losses, easy to remove slag and exceptional mechanical properties even at low temperatures.					
Base materials					
S235JR-S355JR, S235JO-S355JO, S235J2-S355J2, S275N-S355N, S275M-S355M, S275NL-S355NL, S275ML-S355ML, P235GH-P355GH, P275NL1-P355NL1, P275NL2-P355NL2, P215NL, P265NL, P355N, P285NH-P355NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L360NB, L245MB-L360MB, GE200-GE240 Ship building steels: A, B, D, E, A 32-E 36 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1, LF2; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A; A 633 Gr. A, C, D; A 662 Gr. A, B, C; A 707 Gr. L1, L3; A 711 Gr. 1013; A 841 Gr. A, B, C; API 5 L Gr. B, X42, X52, X56					
Typical analysis of all-weld metal (wt.-%)					
	Gas	C	Si	Mn	
wt-%	M21	0.07	0.40	1.40	
wt-%	C1	0.06	0.30	1.30	
Mechanical properties of all-weld metal					
Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J	
	MPa	MPa	%	-40°C	-60°C
u	450 (≥420)	550 (500–640)	28 (≥20)	140 (≥47)	100
u1	430 (≥420)	530 (500–640)	30 (≥20)	90 (≥47)	80
u	untreated, as welded – shielding gas M21				
u1	untreated, as welded – shielding gas C1				
Operating data					
	Polarity: DC (+)	Shielding gases: (EN ISO 14175) M21 – M35; C1	ø (mm)		
			1.0		
			1.2		
			1.4		
			1.6		
Welding with standard GMAW-facilities possible					
Approvals					
TÜV, CE					