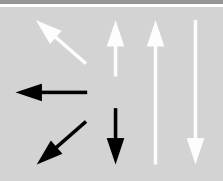


Classifications							
EN ISO 18276-A	EN ISO 18276-B	AWS A5.36	AWS A5.36M				
T69 4 Mn2NiCrMo B C 3 H5	T764T5-0CA-N4C1M2-UH5	E110T5-C1A4-K4-H4	E760T5-C1A4-K4-H4				
Characteristics and typical fields of application							
<p>Seamless basic flux cored wire for welding of high strength Nickel-Chromium-Molybdenum alloyed steels with pure CO₂ shielding gas. Features include: excellent weldability in flat and horizontal positions, smooth and bright bead, low spatter losses easy to remove slag, exceptional mechanical properties at low temperatures (-40°C) with low content of diffusible hydrogen (<3ml/100g).</p>							
Base materials							
<p>S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1 ASTM A 514 Gr. F, H, Q ; A 709 Gr. 100 Type B, E, F, H, Q ; A 709 Gr. HPS 100W</p>							
Typical analysis of all-weld metal (wt.-%)							
	Gas	C	Si	Mn	Ni	Cr	Mo
wt-%	C1	0.07	0.35	1.40	2.10	0.40	0.50
Mechanical properties of all-weld metal							
Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J			
	MPa	MPa	%	-40°C			
u	720 (≥690)	830 (770–900)	18 (≥17)	80 (≥47)			
u untreated, as welded – shielding gas C1							
Operating data							
	Polarity: DC (+)	Shielding gas: (EN ISO 14175) C1	ø (mm)				
			1.2				
			1.4				
1.6							
Welding with standard GMAW-facilities possible							
Approvals							
CE							