

## Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.36	AWS A5.36M
T46 6 Z B M 3 H5	T556T5-0MA-G-H5	E80T5-M21A8-GH4	E550T5-M21A6-GH4

## Characteristics and typical fields of application

Seamless basic, Copper-Nickel alloyed, flux cored wire for single- or multilayer welding of corrosion resistant steels with Ar-CO<sub>2</sub> shielding gas.

Features include: excellent weldability in flat and horizontal positions, smooth and bright bead, low spatter losses, easy to remove slag and exceptional mechanical properties at low temperatures (-60°C).

## Base materials

S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W

ASTM A 588 Gr. A, B, C, K; A 618 Gr. II; 709 Gr. C

## Typical analysis of all-weld metal (wt.-%)

	Gas	C	Si	Mn	Ni	Cu
wt-%	M21	0.05	0.45	1.20	1.20	0.50

## Mechanical properties of all-weld metal

Condition	Yield strength R <sub>e</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	%	-60°C
u	<b>480</b> (≥470)	<b>570</b> (550–680)	<b>30</b> (≥20)	<b>130</b> (≥47)

u untreated, as welded – shielding gas M21

## Operating data

	Polarity:	Shielding gas:	ø (mm)
	DC ( + )	(EN ISO 14175) M21	1.0
			1.2
			1.4
			1.6

Welding with standard GMAW-facilities possible

## Approvals

CE