

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.36	AWS A5.36M
T46 6 Z M M 1 H5	T556T15-1MA-G-H5	E80T15-M21A8-GH4	E550T15-M21A6-GH4

Characteristics and typical fields of application

Seamless, Nickel-Copper alloyed, metalcored wire for single- or multilayer welding of corrosion resistant steels with Ar-CO₂ shielding gas.

Features include: high yield, good weldability, excellent bead appearance, low spatter losses and exceptional mechanical properties at low temperatures. This wire is especially suitable for bridge constructions and chimney.

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	0.06	0.45	1.20	0.50	0.50

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	490 (≥470)	590 (550–680)	27 (≥20)	100	70 (≥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