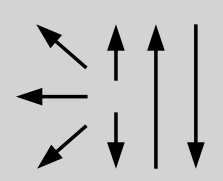


Classifications						
EN ISO 17632-A	EN ISO 17632-B	AWS A5.36	AWS A5.36M			
T46 4 Z P M 1 H5	T554T1-1MA-G-H5	E81T1-M21A4-GH4	E551T1-M21A4-GH4			
Characteristics and typical fields of application						
Seamless rutile, Nickel-Copper alloyed, flux cored wire for single- or multilayer welding of atmospheric corrosion resistant steels with Ar-CO ₂ shielding gas. Main features: excellent weldability, good bead appearance and easy slag removal.						
Base materials						
S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W, Cor-ten A, Patinax 37 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	0.40	1.20	1.20	0.40
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		
u	530 (≥470)	620 (550–680)	25 (≥20)	70 (≥47)		
u untreated, as welded – shielding gas M21						
Operating data						
	Polarity: DC (+)		Shielding gas: (EN ISO 14175) M21		ø (mm)	
					1.0	
					1.2	
					1.4	
				1.6		
Welding with standard GMAW-facilities possible						
Approvals						
CE						