

Classifications				
EN 758		ASME IIC SFA 5.20-01		
T 42 Z W N 4		E 70 T-4		
Characteristics				
Open-arc flux cored wire designed for joining and rebuilding of mild and low alloy steels. High deposition rate for applications in flat positions. Highly crack resistant and easy slag removal properties.				
Microstructure:	Ferrite			
Machinability:	Good			
Oxy-acetylene cutting:	Possible			
Deposit thickness:	No restriction			
Shielding gas:	Not applicable			
Field of use				
Joining and build-up of carbon steels. Maintenance of slag ladles in steelmaking processes.				
Typical analysis in %				
C	Mn	Si	Al	Fe
0.28	0.4	0.1	1.50	balance
Typical mechanical properties				
Hardness as welded: 190 HB				
Recommended welding parameters				
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	
2.0	200 – 550	26 – 35	25 – 50	