

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.29 / SFA-5.29
T 46 6 Z B M21 3 H5	T 55 6 T5-0M21A-G-H5	E80T5-WGM H4

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-CO₂ 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; A 709 Gr. 50 WF3

Typical analysis

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

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J
	MPa	MPa	%	-60°C
u	480 (≥ 470)	570 (550–680)	30 (≥ 20)	130 (≥ 47)

u untreated, as welded – shielding gas M21

Operating data

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

Welding with conventional or pulsed power sources using DC+

Approvals

CE