

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.28 / SFA-5.28
T 46 6 Z M M21 1 H5	T 55 6 T15-1M21A-G-H5	E80C-G H4

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; A 709 Gr. 50 WF3

Typical analysis

	Gas	C	Si	Mn	Ni	Cu
wt.-%	-	0.06	0.45	1.20	0.50	0.50

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

Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J	
	MPa	MPa	%	-40°C	-60°C
u	490 (≥ 470)	590 (550–680)	27 (≥ 20)	100	70 (≥ 47)

Operating data

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

Welding with standard GMAW-facilities possible

Approvals

CE