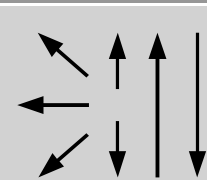


Classifications						
EN ISO 17632-A		EN ISO 17632-B		AWS A5.36		AWS A5.36M
T46 3 P C1 1 H5		T553T1-1C1A-H5		E71T1-C1A2-CS1-H4		E491T1-C1A3-CS1-H4
Characteristics and typical fields of application						
Seamless rutile flux cored wire for single- or multilayer welding of Carbon, Carbon-Manganese steels and similar types of steels including fine grain steels with pure CO2 shielding gas. Main features: excellent weldability in all positions especially vertical upward position, also with high parameters (300 A), very low spatter losses, fast freezing, easy to remove slag and smooth and bright bead. This wire is especially suitable for ship building where excellent performance and welding speed are needed.						
Base materials						
S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240 Ship building steels: A, B, D, E, A 32-E 36 ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65						
Typical analysis of all-weld metal (wt.-%)						
	Gas	C	Si	Mn		
wt-%	C1	0.065	0.45	1.3		
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	%	+20°C	-20°C	-30°C
u	520 (≥460)	580 (550–660)	25 (≥20)	100	95	70 (≥47)
u untreated, as welded – shielding gas C1						
Operating data						
	Polarity: DC (+)	Shielding gas: (EN ISO 14175) C1	ø (mm)			
			1.0			
			1.2			
			1.4			
				1.6		
Welding with standard GMAW power source possible						
Approvals						
TÜV(12573), DB(42.014.45), GL(3YH5S), DNV(3YMS(H5)), ABS(3YSAH5), LR, BV(SA3YM), RINA(3YSH5), RS(3Y40MSH5), CE						