

## Flux cored wire

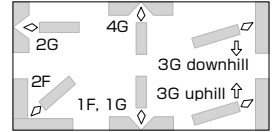
**Features:** ▪ Soft and stable arc, less fume and spattering, smooth bead appearance, and good slag removal

**Classification:** AWS A5.20 E71T-1C

**Shielding gas:** CO<sub>2</sub>

**Polarity:** DCEP

## Welding Positions:



## Packaging data

| φ mm             | Spool            |      |      | Drum         |              |
|------------------|------------------|------|------|--------------|--------------|
|                  | 12.5kg           | 15kg | 20kg | 250kg        | -            |
| 1.2              | 12.5kg           | 15kg | 20kg | 250kg        | -            |
| 1.4              | -                | 15kg | 20kg | 250kg        | 350kg        |
| 1.6              | -                | 15kg | 20kg | -            | 350kg        |
| <b>Volume mm</b> | 300W, 110H, 300L |      |      | 530 φ , 820H | 680 φ , 770H |

## Composition (all-weld metal mass%)

|           | Typical | Guaranty <sup>a</sup> |
|-----------|---------|-----------------------|
| <b>C</b>  | 0.05    | 0.12                  |
| <b>Si</b> | 0.45    | 0.90                  |
| <b>Mn</b> | 1.35    | 1.75                  |
| <b>P</b>  | 0.01    | 0.03                  |
| <b>S</b>  | 0.01    | 0.03                  |
| <b>Ni</b> | 0.01    | 0.50                  |
| <b>Cr</b> | 0.02    | 0.20                  |
| <b>Mo</b> | 0.01    | 0.30                  |
| <b>V</b>  | 0.01    | 0.80                  |
| <b>Cu</b> | 0.02    | 0.35                  |

Note: <sup>a</sup>Single values are maximum.

## All-weld mechanical properties

|                     | Typical | Guaranty |
|---------------------|---------|----------|
| <b>0.2%YS (MPa)</b> | 510     | 400min.  |
| <b>TS (MPa)</b>     | 570     | 490~655  |
| <b>EI on 4d (%)</b> | 30      | 22min.   |
| <b>IV -18°C (J)</b> | 85      | 27min.   |

## Approvals

|               |                          |
|---------------|--------------------------|
| <b>ABS</b>    | 2YSA, 2Y400SA, H10       |
| <b>LR</b>     | 2YS, 2YM, H10            |
| <b>DNV-GL</b> | II YMS, II Y40MS, H10    |
| <b>BV</b>     | SA2M, SA2YM, SA2Y40M H10 |
| <b>NK</b>     | KSW52Y40G (C) H10        |
| <b>CR</b>     | 2YS-HH                   |
| <b>KR</b>     | 2YSG (C)                 |
| <b>CCS</b>    | 2SH10, 2YSH10            |

## Welding parameters (A)

| φ mm | 1F, 1G, 2F | 2G      | 3G uphill, 4G | 3G downhill |
|------|------------|---------|---------------|-------------|
| 1.2  | 120~300    | 120~280 | 120~260       | 200~300     |
| 1.4  | 160~350    | 160~320 | 160~270       | 220~300     |
| 1.6  | 200~400    | 200~350 | 200~280       | 250~300     |