

Flux cored wire

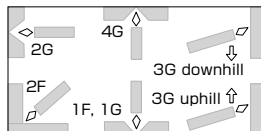
- Features:**
- Excellent usability with soft and stable arc, less fume and spattering, good bead appearance and smooth slag removal

Classification: AWS A5.20 E71T-1M

Shielding gas: Ar-CO₂

Polarity: DCEP

Welding Positions:



Packaging data

Ø mm	Spool	
	1.2	15kg
1.6	15kg	-
Volume mm	300W, 110H, 300L	

Composition (all-weld metal mass%)

	Typical	Guaranty ^a
C	0.07	0.12
Si	0.48	0.90
Mn	1.16	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.01	0.50
Cr	0.02	0.20
Mo	0.01	0.30
V	0.01	0.08
Cu	0.01	0.35

Note: ^a Single values are maximum.

All-weld mechanical properties

	Typical (AC)	Guaranty
0.2%YS (MPa)	510	400min.
TS (MPa)	570	490~655
EI on 4d (%)	30	22min.
IV -18°C (J)	110	27min.

Approvals

ABS	3YSA, H5
LR	3YS, H5
DNV-GL	III YMS, MG, H5
BV	SA3YM H5
NK	KSW52G (M2), H5

Welding parameters (A)

Ø mm	1F, 1G	2F	2G	3G uphill, 4G	3G downhill
1.2	120~300	120~300	120~280	120~260	200~300
1.6	180~450	180~400	180~350	180~280	250~300