

Classifications

EN ISO 17632-A:2015	: T42 4 P M21 1	AWS A5.20-2005(R2015)	: E71T-9MJ
EN ISO 17632-B:2015	: T49 4 T1-1M21 A-U	AWS A5.36-2016	: E71T1-M21A4-CS1
JIS Z 3313-2009	: T49 4 T1-1M A-U	KS D 7104-2012	: YFL-A504R

Description

- It is designed for the welding of 490MPa low-temperature steels with Ar+20%CO₂ shielding gas.
- Typical applications include railcar, automotive machinery, shipbuilding, bridges, heavy equipment etc
- This wire is a titania type of flux cored wire for all-position welding.
- It features excellent mechanical properties, easy slag removal, low spatter generation, and good impact value at low temperatures down to -40℃

Welding positions**Polarity & shielding gas**

- Mix: Ar+20%CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Ni
Mix	0.02	0.40	1.35	0.017	0.018	0.35

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30℃	-40℃	
AWS A5.20	min. 390	490~670	min. 22		≥ 27	
EN ISO 17632-B	min. 390	490~670	min. 18		≥ 47	
Example	610	640	27	140	125	Mix

Notes on usage and welding condition

- Refer to page 219~221 for more information on usage
- In order to prevent crack at low temperatures, preheat and maintain interpass temperature at 100~200℃

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		