

Closed-shape flux-cored wire electrode with rutile, fast-freezing slag for gas-shielded metal arc welding of unalloyed steels for operating temperatures from -40°C up to +450°C in all welding positions with spray arc featuring increased welding parameters and increased deposition rates. Very good slag removal, smooth seam surface without undercutting into the base metal. Very good mechanical property in as welded and after PWHT. Can be welded in all positions with one setting of parameters. Very well suited for use on ceramic weld pool backing. To be used under CO<sub>2</sub> as shielding gas.

### Classification

EN ISO	17632-A: T 46 4 P C 1 H5
AWS	A5.20: E71T-12C JH4
AWS	A5.20: E71T-1C JH4

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S	Ni
0.06	1.2	0.4	≤ 0.015	≤ 0.015	0.4

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation A5 (%)	Impact Energy ISO - V (J)	
				-40 °C	-50 °C
As Welded	≥ 460	510-610	≥ 24	≥ 80	≥ 47
580 °C x 2 h/f.	≥ 460	510-610	≥ 24	≥ 80	

Gas test: 100% CO<sub>2</sub>

**Shielding Gas** - EN ISO 14175 : C1

### Materials

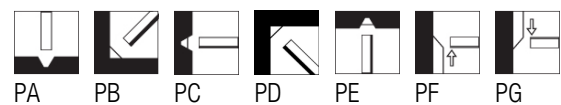
S(P)235-S(P)460, GP240-GP280

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



### Packaging data

Packaging Type	B300	S200
Diam(mm) / weight(kg)	16	5
1.2	●	●