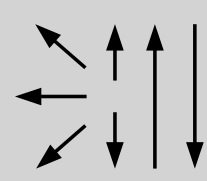


Classifications					
EN ISO 17632-A		EN ISO 17632-B		AWS A5.36	
AWS A5.36M					
T46 Z Y N 1		T55T11-1N-H10		E71T11-AZ-CS3-H8	
E491T11-AZ-CS3-H8					
Characteristics and typical fields of application					
Self-shielded seamless flux cored wire designed for all position welding of low and medium alloyed steels. This wire is especially useful for on-site fabrication, structural or repair welding applications, single or multipass welding. Main features: good weldability, also vertical-up Position, good bead appearance, low spatter levels and easy to remove slag. The copper coated surface provides high resistance to rust and the seamless technology grants low moisture pick-up with low content of diffusible hydrogen levels (< H8).					
Base materials					
S235JR-S355JR, P355N, P195TR1-P265TR1, L210GA-L360 GA, L245NB-L415NB, L450QB, L245MB-L450MB ASTM A 106 Gr. A, B; A 181 Gr. 60; A 283 Gr. A; A 285 Gr. A, B; A 414 Gr. A, B; A 501 Gr. B; A 516 Gr. 55, 60; A 573 Gr. 55, 58; A 588 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65					
Typical analysis of all-weld metal (wt.-%)					
	Gas	C	Si	Mn	Al
wt-%	-	0.25	0.40	1.00	1.50
Mechanical properties of all-weld metal					
Condition	Yield strength R _e		Tensile strength R _m		Elongation A (L ₀ =5d ₀)
	MPa		MPa		%
u	530 (≥460)		640 (550–660)		24 (≥20)
u untreated, as welded					
Operating data					
	Polarity: DC (–)			ø (mm)	
				0.8	
				0.9	
				1.0	
				1.2	
				1.4	
				1.6	
Welding with standard GMAW-facilities possible					
Approvals					
CE					