diamondspark 31 NG

Flux cored wire, seamless, self-shielded, unalloyed

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.20 / SFA-A5.20
T 42 Z Y NO 1 H10	T 49 T11-1NO-H10	E71T-11

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, generally not recommended for the welding of materials over 20 mm thickness.
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

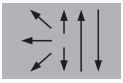
	Gas	C	Si	Mn	Al
wt.-%	-	0.25	0.40	1.00	1.50

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_{p0.2}$	Tensile strength R_m	Elongation A (L_0=5d_0)
	Mpa	Mpa	%
u	440 (≥420)	600 (500-640)	24 (≥22)

u untreated, as welded

Operating data



Polarity	DC-
Shielding gas (EN ISO 14175)	NO GAS

Dimension mm
1.0
1.2
1.4
1.6

welding with standard GMAW power source possible

Approvals

CE