

## Classifications

EN ISO 18276-A	EN ISO 18276-B	AWS A5.29 / SFA-5.29
T 62 4 Mn1.5Ni P M21 1 H5	T 69 4 T1-1M21A-N3M1-UH5	E101T1-K2M-JH4

## Characteristics and typical fields of application

Seamless rutile nickel-molybdenum alloyed flux-cored wire for single or multilayer welding of carbon, carbon-manganese steels and high strength steels with Ar-CO<sub>2</sub> shielding gas.

Main features: excellent weldability in all positions, excellent bead appearance, low spatter losses, fast freezing and easy to remove slag. The exceptional mechanical properties of this wire even at low temperatures as well as the low content of diffusible hydrogen make it especially suitable for off-shore applications.

## Base materials

S500Q-S620Q, S500QL-S620QL, L485MB-L555MB, L485QB-L555QB, alform 500 M, 550 M, 600 M, aldur 550 Q, 550 QL, 620 M, PAS 460-550  
ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X70, X80, X70Q, X80Q

## Typical analysis

	Gas	C	Si	Mn	Ni	Mo
wt.-%	M21	0.05	0.30	1.30	1.50	0.30

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

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	Impact energy ISO-V KV J
	MPa	MPa	%	-40°C
u	670 (≥ 620)	730 (700-760)	20 (≥ 18)	90 (≥ 47)

u untreated, as welded – shielding gas M21

## Operating data

	<b>Polarity</b>	DC+	<b>Dimension mm</b>
	<b>Shielding gas (EN ISO 14175)</b>	M21	
			1.6

Welding with standard GMAW-facilities possible

## Approvals

CE