diamondspark X80 RC-Pipe

Flux-cored wire, seamless, for automatic pipeline welding, rutile type

Classifications

EN ISO 18276-A	EN ISO 18276-B	AWS A5.29 / SFA-5.29	AWS A5.36 / SFA-5.36
T 62 4 Mn1.5Ni P M21 1 H5	T 69 4 T1-1M21A-N3M1-UH5	E101T1-K2M-JH4	E101T1-M21A4-K2-H4

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-CO2 shielding gas. The wire is especially designed for semi- and fully automatic welding in pipeline applications for high strength steels X80-X90 base materials thanks to exceptional mechanical properties at low temperatures as well as the low content of diffusible hydrogen. Main features: excellent weldability in all positions, in particular in overhead with very stable arc at lower welding parameters, excellent bead appearance, low spatter losses, fast freezing and easy to remove slag.

Base materials

API 5L: X80, X90
EN 3183: L555. L625

Typical analysis

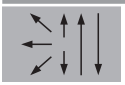
	Gas	C	Si	Mn	Ni	Mo
wt.-%	M21	0.04	0.45	1.45	1.60	0.15

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)	Impact energy ISO-V KV J
	MPa	MPa	%	-40°C
u	680 (=>620)	720 (700–760)	22 (=>18)	80 (=>47)

u - untreated, as welded – shielding gas M21 (Ar + 15 – 25 % CO2)

Operating data



Polarity	DC +	Dimension mm
Shielding gas (EN ISO 14175)	M21: Ar + 15 – 25 % CO2	1.2

Welding with standard GMAW power source possible

Approvals

CE