

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-CO₂ 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 $R_{p0.2}$	Tensile strength R_m	Elongation A ($L_0=5d_0$)	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

	Polarity	DC+	Dimension mm
	Shielding gas	M21	1.2
	(EN ISO 14175)		1.6

Welding with standard GMAW-facilities possible

Approvals

CE