

## Flux cored wire

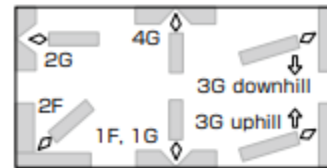
**Features:** • Soft and stable arc, less fume and spattering, smooth bead appearance, and good slag removal

**Classification:** AWS A5.20 E71T-1C

**Shielding gas:** CO<sub>2</sub>

**Polarity:** DCEP

## Welding Positions:



## Packaging data

φ mm	Spool			Drum	
	12.5kg	15kg	20kg	250kg	-
1.2	12.5kg	15kg	20kg	250kg	-
1.4	-	15kg	20kg	250kg	350kg
1.6	-	15kg	20kg	-	350kg
<b>Volume mm</b>	300W, 110H, 300L			530 φ, 820H	680 φ, 770H

## Composition (all-weld metal mass%)

	Typical	Guaranty <sup>a</sup>
<b>C</b>	0.05	0.12
<b>Si</b>	0.45	0.90
<b>Mn</b>	1.35	1.75
<b>P</b>	0.01	0.03
<b>S</b>	0.01	0.03
<b>Ni</b>	0.01	0.50
<b>Cr</b>	0.02	0.20
<b>Mo</b>	0.01	0.30
<b>V</b>	0.01	0.80
<b>Cu</b>	0.02	0.35

Note: <sup>a</sup> Single values are maximum.

## All-weld mechanical properties

	Typical	Guaranty
<b>0.2%YS (MPa)</b>	510	400min.
<b>TS (MPa)</b>	570	490~655
<b>El on 4d (%)</b>	30	22min.
<b>IV -18°C (J)</b>	85	27min.

## Approvals

<b>ABS</b>	2YSA, 2Y400SA, H10
<b>LR</b>	2YS, 2YM, H10
<b>DNV</b>	II YMS, H10
<b>BV</b>	SA2M, SA2YM, SA2Y40M H10
<b>NK</b>	KSW52Y40G (C) H10
<b>GL</b>	II Y40MSH10
<b>CR</b>	2YS-HH
<b>KR</b>	2YSG (C)
<b>CCS</b>	2SH10, 2YSH10

## Welding parameters (A)

φ mm	1F, 1G, 2F	2G	3G uphill, 4G	3G downhill
1.2	120~300	120~280	120~260	200~300
1.4	160~350	160~320	160~270	220~300
1.6	200~400	200~350	200~280	250~300