

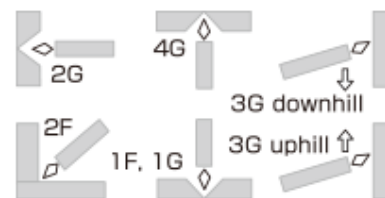
Flux cored wire

Features: • Excellent usability with soft and stable arc, less fume and spattering, good bead appearance and smooth slag removal

Classification: AWS A5.20 E71T-1C/1M, -9C/9M

Shielding gas: CO₂ or Ar-CO₂ mixture

Polarity: DCEP

Welding Positions:

Packaging data

φ mm	Spool			Drum
	5kg	15kg	20kg	
1.2	5kg	15kg	20kg	250kg
1.6	-	15kg	20kg	250kg
Volume mm	220W, 130H, 435L/4pcs	300W, 110H, 300L		530φ, 820H

Composition (all-weld metal mass %)

	Typical (CO ₂)	Guaranty ^a
C	0.04	0.12
Si	0.67	0.90
Mn	1.29	1.75
P	0.01	0.03
S	0.01	0.03
Ni	0.01	0.50
Cr	0.03	0.20
Mo	0.01	0.30
V	0.02	0.08
Cu	0.02	0.35

Note: ^aSingle values are maximum.

Welding parameters (A)

φ mm	1F, 1G, 2F, 2G	3G uphill, 4G	3G downhill
1.2	120-250	120-250	200-250
1.6	180-340	180-280	250-300

All-weld mechanical properties

	Typical (CO ₂)	Guaranty
0.2%YS (MPa)	510	400min.
TS (MPa)	582	490-655
EI on 4d (%)	27	22min.
IV -29°C (J)	71	27min.

Approvals

ABS	3YSA, H5
LR	3YS, H5
DNV	ⅢYMS (H5)
NK	KSW53G (C), H5
GL	ⅢYMS (H5)
CWB	E491T-9-H8, E491T-9M-H8