



Product Data Sheet

T 'Tubular cored electrode arc welding'

Coreweld 46 LS

Prepared by Daniel Amahatsion	Qualified by P-O Oskarsson	Approved by Neil Farrow	Reg no EN007549	Cancelling EN007548	Reg date 2017-06-02	Page 1 (2)
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REASON FOR ISSUE

EN ISO classifications amended

GENERAL

A metal cored wire which gives a very low amount of silica on the weld surface. Designed for welding thin plate (>1mm) as well as thicker sections with argon / carbon dioxide shielding gas. The wider welding arc produced means larger gaps can be bridged than with solid wire.

Shielding Gas: M20, M21 (EN ISO 14175)

Polarity: DC+

Alloy Type: C Mn steel

Fill Type: Metal cored

Diff Hydrogen: < 4 ml/100g

CLASSIFICATIONS Weld Metal

SFA/AWS A5.36	E71T15-M20A4-CS1 H4
SFA/AWS A5.36	E71T15-M21A4-CS1 H4
EN ISO 17632-A	T 46 4 M M20 2 H5
EN ISO 17632-A	T 46 4 M M21 2 H5

APPROVALS

ABS	4Y40M H5 (M20)	
ABS	4Y40M H5 (M21)	
BV	4Y40 H5 (M20)	(1.2mm)
BV	4Y40 H5 (M21)	(1.2mm)
CE	EN 13479	
DB	42.039.38	(1.2mm)
DNV	IV Y40MS(H5) (M20)	
DNV	IV Y40MS(H5) (M21)	
GL	4Y40H5S (M20)	(1.2mm)
GL	4Y40H5S (M21)	(1.2mm)
VdTÜV	12152	(1.2mm)

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C	0.03	0.10
Si	0.40	0.80
Mn	1.10	1.60
P		0.030
S		0.030
Cr		0.20
Ni		0.50
Mo		0.20
V		0.08
Nb		0.05
Cu		0.30

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded		
	Min	Max	Typ
Rp0.2 (MPa)	460		485
Rm (MPa)	530	680	545
A5 (%)	22		29
Charpy V at -40°C (J)	47		72



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W	η	H		Feed			U
	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
1.2	100	360	20	95	1.3	8.0	1.8	13.0	16	32
1.4	150	380	20	95	1.8	7.0	2.5	9.0	18	34
1.6	150	450	20	95	1.7	7.8	2.0	9.3	17	36

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)