

Prepared by Daniel Amahatsion	Qualified by P-O Oskarsson	Approved by Neil Farrow	Reg no EN007571	Cancelling EN007179	Reg date 2017-06-20	Page 1 (2)
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REASON FOR ISSUE

EN ISO classifications updated

GENERAL

A downhand rutile cored wire for use with C1 or M21 shielding gas.

Shielding Gas: M21, C1 (EN ISO 14175)

Alloy Type: Low alloy (<1% Ni)

Polarity: DC+

Fill Type: Rutile

CLASSIFICATIONS Weld Metal

SFA/AWS A5.36	E70T1-C1A0-G
SFA/AWS A5.36	E70T1-M21A0-G
EN ISO 17632-A	T 42 2 1Ni R C1 3 H10
EN ISO 17632-A	T 46 2 1Ni R M21 3 H10

APPROVALS

ABS	3SA, 3YSA H10
BV	S3M, S3YM HH (C1)
BV	S3M, S3YM HH (M21)
CE	EN 13479
CRS	3Y H10S (C1)
CRS	3Y H10S (M21)
DB	42.105.06
DNV	III YMS (H10) (C1)
DNV	III YMS (H10) (M21)
GL	3Y H10S
LR	3YS H10 (C1)
LR	3YS H10 (M21)
PRS	3YS H10 (C1)
PRS	3YS H10 (M21)
VdTÜV	03013

CHEMICAL COMPOSITION

All Weld Metal (%)

	Shielding Gas M21	
	Min	Max
C	0.04	0.08
Si	0.30	0.60
Mn	0.80	1.20
P		0.025
S		0.030
Cr		0.2
Ni	0.60	0.90
Mo		0.2
V		0.08
Nb		0.05
Cu		0.3

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MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	C1 shielding gas			M21 shielding gas		
	As welded			As welded		
	Min	Max	Typ	Min	Max	Typ
Rp0.2 (MPa)	420		465	460		495
Rm (MPa)	510	580	530	545	630	576
A5 (%)	26		28	26		26
Charpy V at -20°C (J)	54		89	54		114

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H		Feed		U	
$\emptyset$	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max
1.2	150	350	20	85	2.1	7.5	5.8	20.7	27	38
1.4	150	350	20	85	1.8	6.3	3.4	12.0	26	36
1.6	150	450	20	85	1.6	8.1	2.8	12.4	24	40

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)