

Signed by Neil Farrow	Approved by Neil Farrow/Christos Skodras	Reg no EN005205	Cancelling EN005139	Reg date 2010-03-30	Page 1 (2)
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REASON FOR ISSUE

LR approval updated

GENERAL

A metal cored wire designed for welding with Ar/CO2 shielding gas mixture. Diameters less than 1.4mm are all-positional except vertical down.

Shielding Gas: M21 (EN ISO 14175)

Polarity: DC+

Alloy Type: CMn

Fill Type: Metal cored

CLASSIFICATIONS Weld Metal

SFA/AWS A5.18 E70C-6M H4
EN ISO 17632-A T 46 4 M M 2 H5

APPROVALS

ABS 3SA, 3YSA
BV S3M, S3YM HH (M21)
CE EN 13479
DB 42.105.09
DNV IV YMS (H5) (M21)
GL 4YH10S (M21)
LR 4Y46S H5
VdTÜV 04901

CHEMICAL COMPOSITION

	All Weld Metal (%)	
	Min	Max
	M21 shielding gas	
C	0.06	0.09
Si	0.50	0.80
Mn	1.35	1.75
P		0.025
S		0.030
Cr		0.2
Ni		0.5
Mo		0.2
V		0.08
Nb		0.05
Cu		0.3

MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal	
	Min	Max
	M21 shielding gas	
	As welded	
ReL (MPa)	460	
Rm (MPa)	530	630
A5 (%)	24	
Charpy V at -40°C (J)	47	

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ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W		η		H		Feed		U
$\emptyset$	Min	Max	Nom	Nom	Min	Max	Min	Max	Min	Max	Max
1.2	130	350	20	95	2.0	8.0	4.6	18.5	16		34
1.4	150	350	20	95	1.8	6.7	2.5	8.8	18		33
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)