

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.29 / SFA-5.29	AWS A5.36 / SFA-5.36
T 46 4 Z P M21 1 H5	T 55 4 T1-1M21A-G-H5	E81T1-WGM H4	E81T1-M21A4-GH4

Characteristics and typical fields of application

Seamless rutile, Nickel-Copper alloyed, flux cored wire for single- or multilayer welding of atmospheric corrosion resistant steels with Ar-CO₂ shielding gas. Main features: excellent weldability, good bead appearance and easy slag removal.

Base materials

S235JRG2Cu, S235J2G4Cu, S235J0Cu, S235JRW, S355J0Cu, S355J2G3Cu, S355J0W, 235J2W-S355J2W, S355K2W, Cor-ten A, Patinax 37

ASTM A 588 Gr. A, B, C, K; A 618 Gr. II; A 709 Gr. 50 WF3

Typical analysis


	Gas	C	Si	Mn	Ni	Cu
wt.-%	M21	0.05	0.40	1.20	1.10	0.50

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J
	MPa	MPa	%	-40 °C
u	530 (≥ 470)	620 (550–680)	25 (≥ 20)	70 (≥ 47)

u untreated, as welded – shielding gas M21

Operating data

	Polarity	DC+	Dimension mm
	Shielding gas (EN ISO 14175)	(EN ISO 14175) M21	1.0
			1.2
			1.4
			1.6

Welding with standard GMAW power source possible

Approvals

CE