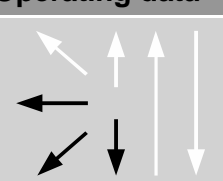


Classifications						
EN ISO 18276-A	EN ISO 18276-B	AWS A5.36	AWS A5.36M			
T55 4 1NiMo B M21 3 H5	T624T5-0M21A-N2M2-UH5	E90T5-M21A4-GH4	E620T5-M21A4-GH4			
Characteristics and typical fields of application						
Seamless basic flux cored wire for welding of high strength Nickel-Molybdenum alloyed steels with Ar-CO ₂ shielding gas. Features include: excellent weldability in flat and horizontal positions, smooth and bright bead, very low spatter losses, easy to remove slag, exceptional mechanical properties at low temperatures with low content of diffusible hydrogen in the weld metal (< 3ml/100g).						
Base materials						
S420N-S460N, S420M-S460M, S460Q-S555Q, S460QL-S550QL, P460N,P460NH, L415NB, L415MB-L555MB, L415QB-L555QB, PAS 460-550, alform 500 M, 550 M, aldur 500 Q, 500 QL, aldur 550 Q, 550 QL, 20MnMoNi4-5, 15NiCuMoNb5-6-4 ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X60, X65, X70, X80, X60Q, X65Q, X70Q, X80Q						
Typical analysis of all-weld metal (wt.-%)						
	Gas	C	Si	Mn	Ni	Mo
wt-%	M21	0.05	0.35	1.40	1.20	0.40
Mechanical properties of all-weld metal						
Condition	Yield strength R _{p0.2}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	-40°C		
u	590 (≥550)	670 (640–760)	22 (≥18)	100 (≥47)		
u untreated, as welded – shielding gas M21						
Operating data						
	Polarity: DC (+)	Shielding gas: (EN ISO 14175) M21		ø (mm)		
				1.2		
				1.4		
				1.6		
Welding with standard GMAW power source possible						
Approvals						
CE						