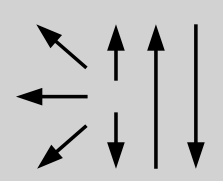


Classifications							
EN ISO 17632-A	EN ISO 17632-B	AWS A5.36	AWS A5.36M				
T46 4 Z P M21 1 H5	T554T1-1M21A-G-H5	E81T1-M21A4-GH4	E551T1-M21A4-GH4				
Characteristics and typical fields of application							
Seamless rutile, Nickel-Copper alloyed, flux cored wire for single- or multilayer welding of weathering resistant constructional steels with Ar-CO ₂ 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; 709 Gr. C							
Typical analysis of all-weld metal (wt.-%)							
	Gas	C	Si	Mn	Ni	Cu	
wt-%	M21	0.05	0.40	1.20	1.10	0.50	
Mechanical properties of all-weld metal							
Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work 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 (+)	Shielding gas: (EN ISO 14175) M21	ø (mm)				
			1.0				
			1.2				
			1.4				
				1.6			
Welding with standard GMAW power source possible							
Approvals							
CE							