BÖHLER Ti 75 T-FD

Flux cored wire, seamless, high strength, rutile type

Classifications

EN ISO 18276-A	EN ISO 18276-B	AWS A5.36	AWS A5.36M
T62 4 Mn1.5Ni P M21 1 H5	T694T1-1M21A-N3M1-UH5	E101T1-M21A4-K2-H4	E691T1-M21A4-K2-H4

Characteristics and typical fields of application

Seamless rutile nickel-molybdenum alloyed flux cored wire for single- or multilayer welding of carbon, carbon-manganese steels and high strength steels with Ar-CO_2 shielding gas.
Main features: excellent weldability in all positions, excellent bead appearance, low spatter losses, fast freezing and easy to remove slag. The exceptional mechanical properties of this wire even at low temperatures as well as the low content of diffusible hydrogen make it especially suitable for off-shore applications.

Base materials

S500Q-S620Q, S500QL-S620QL, L485MB-L555MB, L485QB-L555QB, alform 500 M, 550 M, 600 M, aldur 550 Q, 550 QL, 620 M, PAS 460-550
ASTM A 572 Gr. 65; A 633 Gr. E; A 738 Gr. A; A 852; API 5 L X70, X80, X70Q, X80Q

Typical analysis of all-weld metal (wt.-%)

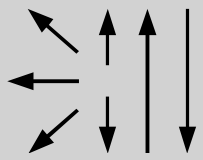
	Gas	C	Si	Mn	Ni	Mo
wt-%	M21	0.05	0.30	1.30	1.50	0.30

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	**670** (≥620)	**730** (700–760)	**20** (≥18)	**90** (≥47)

u untreated, as welded – shielding gas M21

Operating data



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

Welding with standard GMAW power source possible

Approvals

CE