

Signed by Neil Farrow	Approved by Shaun Studholme/Barbro Karlström	Reg no EN002259	Cancelling DCT-90-6113	Reg date 2004-07-01	Page 1 (2)
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## GENERAL

A multi-purpose all positional rutile cored wire for use with C1 or M21 shielding gas. Diameters less than 1.4mm are all-positional except vertical down.

**Shielding Gas:** M21, C1 (EN 439)

**Alloy Type:** CMn

**Polarity:** DC+

**Fill Type:** Rutile

## CLASSIFICATIONS Weld Metal

EN 758	T 42 2 P C 1 H5
EN 758	T 46 2 P M 1 H10
SFA/AWS A5.20	E71T-1 H4
SFA/AWS A5.20	E71T-1M H8

## APPROVALS

Ü	42.105/2
ABS	3SA, 3YSA
BV	SA3 3YMHH
CCS	3Y 40S H10
CL	0452
CRS	3TH10S
DB	42.105.07
DNV	III YMS (H10)
DS	T 46 2 P M 1 H10
DS	T 42 2 P C 1 H10
GL	3YH10S
LR	3S 3YS
PRS	3YH10S
RINA	SG 52 2 / SG 52 3
RS	3YHHS
UDT	EN 758
VdTÜV	04902

## CHEMICAL COMPOSITION

### All Weld Metal (%)

	M21	
	Min	Max
C	0.04	0.08
Si	0.30	0.70
Mn	1.00	1.50
P		0.025
S		0.025

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## MECHANICAL PROPERTIES OF WELD METAL

Properties	All Weld Metal			
	C1 Shielding gas		M21 Shielding gas	
	As welded		As welded	
	Min	Max	Min	Max
Rp0.2 (MPa)	420		460	
Rm (MPa)	510	590	550	640
A4-A5 (%)	22		22	
Charpy V at -20°C (J)	54		54	
	Comments: Elongation = A5		Comments: Elongation = A5	

## ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	$\eta$	H		Feed		U	
	Min	Max			Nom	Nom	Min	Max	Min	Max
$\emptyset$										
1.2	150	350	20	85	2.1	7.5	5.8	20.7	27	38
1.4	150	350	20	85	1.8	6.3	3.3	11.6	26	36
1.6	150	450	20	85	1.8	8.1	2.8	12.4	24	40

**W** = Gas consumption (l / min)

**$\eta$**  = Recovery, g weld metal / 100g wire (%)

**H** = Deposit rate (kg weld metal / hour arc time)

**Feed** = Feeding rate (m/min)

**U** = Arc voltage (V)