

Classifications

EN ISO 17632-A:2008	: T46 0 P C 1 H10	AWS A5.36	: E71T1-C1A0-CS1 H8
EN ISO 17632-B:2008	: T49 0 T1-1CA-U H10		
JIS Z 3313	: T49 0 T1-1CA-U H10		

Description

- It is designed for the mild and medium tensile steels that are used to for flue gasdesulfurization facilities
- The weld metal contain Cu, Co alloys and has good anticorrosion against sulfuric acid
- Wire is a titania type of flux cored wire for all-position welding
- It feature excellent mechanical properties, easy slag removal, low spatter generation, high X-ray safety

Welding positions**Polarity & shielding gas**

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Cu	Co
CO ₂	0.02	0.40	1.00	0.013	0.010	0.38	0.10

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	Temp/(500°C) (MPa)	El. (%)	IV (J) 0°C	Remarks
EN IOS 17632-B	min. 390	490~670		min. 22	≥ 47	
JIS Z 3313	min. 400	490~670		min. 18	≥ 47	
Example	520	580	420	29	64	CO ₂

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		