

Classification

EN ISO 17632-A	EN ISO 17632-B	AWS A5.36	AWS A5.36M
T50 6 1Ni M M 1 H5	T576T15-1MA-N2-UH5	E80T15-M21A8-Ni1-H4	E550T15-M21A6-Ni1-H4

Characteristics and typical fields of application

Seamless, Nickel alloyed, metal cored wire for single- or multilayer welding of carbon, carbon-manganese and high strength steels with Ar-CO₂ shielding gas.

Features include: high yield, good weldability, excellent bead appearance, very low spatter losses and exceptional mechanical properties at low temperatures (-60°C) in as welded conditions as well after post weld heat treatment. This wire is especially suitable for rootpass welding in off-shore and pipeline applications.

Base Materials

S355JR, S355J0, S355J2, S450J0, S355N-S460N, S355NL-S460NL, S355M-S460M, S355ML-S460ML, S460Q, S500Q, S460QL, S500QL, S460QL1, S500QL1, P355GH, P355NH, P420NH, P460NH, P355N-P460N, P355NH-P460NH, P355NL1-P460NL1, P355NL2-P460NL2, L245NB-L415NB, L245MB-L485MB, L360QB-L485QB, aldur 500Q, aldur 500QL, aldur 500QL1

ASTM A 350 Gr. LF2; A 516 Gr. 65, 70; A 572 Gr. 42, 50, 60, 65; A 573 Gr. 70; A 588 Gr. B, C, K; A 633 Gr. A, C, D, E; A 662 Gr. B, C; A 678 Gr. B; A 707 Gr. L2, L3; A 841 Gr. A, B, C; API 5 L X42, X52, X60, X65, X70, X52Q, X60Q, X65Q, X70Q

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

	Gas	C	Si	Mn	Ni		
wt-%	M21	0,06	0,5	1,3	0,9		

Mechanical properties of all-weld metal

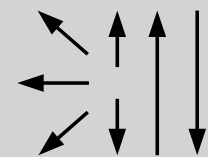
Condition	Yield strength R _e	Tensile strength R _m	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J			
	MPa	MPa	%	RT	-40°C	-50°C	-60°C
u	530 (≥500)	620 (570 - 690)	27 (≥ 18)				65
s	500	560	26				90
n	360	520	33				100

u untreated, as welded – shielding gas M21 (Ar + 18 % CO₂)

s stress relieved 580°C/3h – shielding gas M21 (Ar + 18 % CO₂)

n normalized 920°C/30min – shielding gas M21 (Ar + 18 % CO₂)

Operating data

	Polarity: DC (+)	shielding gases: (EN ISO 14175): M21-M33, C1	re-drying if necessary: -	ø (mm)
				1,0
				1,2
				1,4
				1,6

Preheating and interpass temperature as required by the base metal.

Approvals and Certificates

TÜV, GL, DNV, CE