Key Facts

- Self shielded flux core wire
- Suitable for single pass applications
- Smooth arc action DC-
- No shielding gas required

Description

Self-shielding, all-positional, flux-cored wire for single pass applications. Travel speed is high and weld edges are smooth. It has a smooth arc action, full slag coverage, easy slag removal with low spatter. No shielding gas is required.

The used of DC straight polarity welding current minimises the risk of burn through. Deposition efficiency is higher than that of shielded metal arc electrodes.

Welding Positions

All positions

Classification, Approvals & Conformances

AWS A5.20 E71T-GS
EN 758: T42 ZWN 1H 10

Applications

Generally used in the repair of automotive parts such as cylinder heads, inlet manifolds and housings. Can also be used for defects and cast repairs.

- Excellent on galvanised steel
- General welding and repairs out doors
- Farm repairs and maintenance

Typical Analysis/Composition

C - Carbon	Mn - Manganese	Si - Silicon	Cr - Chromium
< 0.2	0.9 – 1.2%	< 0.45	< 0.05
Ni-Nickel	**Mo - Molybdenum**	**S - Sulphur**	**P - Phosphorus**
< 0.05	<0.03	<0.005	<0.015
Cu - Copper	**Ai - Aluminum**		
< 0.03	0.4 – 1.2%		

Typical Weld Mechanical Properties

0.2% Proof Stress:	> 430 MPa
Tensile Strength:	>480 - 640 MPa
Elongation (5xD):	>22%

Packaging & Ordering Information

Size	Weight	Part Number
0.8mm	0.9 Kg	200342
0.8mm	4.5 Kg	200343
0.9mm	0.9 Kg	200344
0.9mm	15 Kg	200348
0.9mm	4.5 Kg	200345
1.2mm	15 Kg	200347
1.2mm	4.5 Kg	200346