

Classifications			
EN ISO Norme A	EN ISO Classification A	AWS/SFA Norme A	AWS/SFA Classification A
EN ISO 17632-A	T 46 4 P M21 1 H5	AWS A5.20 / SFA-5.20	E71T1M/T-9M/T-12M JDH4
Caractéristiques et domaines d'application			
Description courte	Caractéristiques principales	Applications	
Seamless rutile flux cored wire for single- or multilayer welding of Carbon, Carbon-Manganese steels and similar types of steels including fine grain steels with Argon-CO2 shielding gas or pure CO2. Main features: excellent weldability in all positions with high performance welding speed, very low spatter losses, good bead appearance, fast freezing and easy to remove slag. This wire is especially suitable for ship building, structural steel work or wherever good bead appearance is required. D1.8 Seismic Supplement approved. This product can be used in sour gas applications. (HIC tested acc. to NACE TM-0284). Test values for SSC are available upon request. Typical hydrogen value 2.5 – 3.5ml/100g weld metal.	Excellent weldability in all positions with high performance welding speed, very low spatter losses, good bead appearance, fast freezing and easy to remove slag.	Especially suitable for ship building, structural steel work or wherever good bead appearance is required. D1.8 Seismic Supplement approved. This product can be used in sour gas applications. (HIC tested acc. to NACE TM-0284). Test values for SSC are available upon request.	
Composition chimique type du fil/du métal déposé hors dilution			
C	Si	Mn	
0.06 %	0.4 %	1.45 %	
Propriétés mécaniques - Condition 1			
Condition	Limite d'élasticité Re	Contrainte à la rupture Rm	Allongement A (L0=5d0)
u	500 ($\geq$ 460) MPa	590 (550 - 660) MPa	26 ($\geq$ 22) %
Température 1	Résilience 1 ISO-V KV	Température 2	Résilience 2 ISO-V KV
-46 °C	50 ($\geq$ 27) J	-40 °C	70 ($\geq$ 47) J
Température 3	Résilience 3 ISO-V KV	Remarques	
-20 °C	100 ($\geq$ 47) J	u: untreated, as welded - shielding gas M21; u1: untreated, as welded - shielding gas C1; s1: stress relieved 620°C/1 hour - shielding gas M21	

Propriétés mécaniques - Condition 2			
Condition	Limite d'élasticité Re	Contrainte à la rupture Rm	Allongement A (L0=5d0)
u1	470 ($\geq$ 460) MPa	560 (550 - 660) MPa	28 ($\geq$ 22) %
Température 1	Température 2	Température 3	Résilience 3 ISO-V KV
-46 °C	-40 °C	-20 °C	80 ($\geq$ 47) J
Remarques			
u: untreated, as welded - shielding gas M21; u1: untreated, as welded - shielding gas C1; s1: stress relieved 620°C/1 hour - shielding gas M21			
Propriétés mécaniques - Condition 3			
Condition	Limite d'élasticité Re	Contrainte à la rupture Rm	Allongement A (L0=5d0)
s1	510 ($\geq$ 460) MPa	590 (550 - 660) MPa	26 ($\geq$ 22) %
Température 1	Résilience 1 ISO-V KV	Température 2	Température 3
-46 °C	41 ($\geq$ 27) J	-40 °C	-20 °C
Remarques			
u: untreated, as welded - shielding gas M21; u1: untreated, as welded - shielding gas C1; s1: stress relieved 620°C/1 hour - shielding gas M21			
Details welding consumables			
ABS	BV	CE	CLASS AWS
4Y400 H5	SA4Y40 HHH	X	E71T1M/T-9M/T-12M JDH4
CLASS EN ISO	CWB	DB	DNV-GL
T 46 4 P M21 1 H5	X	X	IV Y40MS(H5) / II YS
LR	NORM AWS	NORM EN ISO	RINA
DXVud0-BF-4Y40S-H5-NA	AWS A5.20 / SFA-5.20	EN ISO 17632-A	4Y 40 S H5
TÜV			
X			