

| Classifications                                                                                                                                                                                                                                                                                                                                                                                                  |                                                                                                                                        |                                                                                   |                          |
|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------|--------------------------|
| EN ISO Norme A                                                                                                                                                                                                                                                                                                                                                                                                   | EN ISO Classification A                                                                                                                | AWS/SFA Norme A                                                                   | AWS/SFA Classification A |
| EN ISO 18276-A                                                                                                                                                                                                                                                                                                                                                                                                   | T 55 6 1NiMo M M21 1 H5                                                                                                                | AWS A5.28 / SFA-5.28                                                              | E90C-K3H4                |
| Caractéristiques et domaines d'application                                                                                                                                                                                                                                                                                                                                                                       |                                                                                                                                        |                                                                                   |                          |
| Description courte                                                                                                                                                                                                                                                                                                                                                                                               | Caractéristiques principales                                                                                                           | Applications                                                                      |                          |
| Seamless, Nickel-Molybdenum alloyed, metalcored wire for single or multilayer welding of low alloyed and high strength steels with Ar-CO2 shielding gas. Features include: high yield, good weldability, excellent bead appearance, low spatter losses and exceptional mechanical properties at low temperatures. This wire is especially suitable for root pass welding in off-shore and pipeline applications. | High yield, good weldability, excellent bead appearance, low spatter losses and exceptional mechanical properties at low temperatures. | especially suitable for root pass welding in off-shore and pipeline applications. |                          |
| Composition chimique type du fil/du métal déposé hors dilution                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                        |                                                                                   |                          |
| C                                                                                                                                                                                                                                                                                                                                                                                                                | Si                                                                                                                                     | Mn                                                                                | Ni                       |
| 0.06 %                                                                                                                                                                                                                                                                                                                                                                                                           | 0.45 %                                                                                                                                 | 1.3 %                                                                             | 1 %                      |
| Mo                                                                                                                                                                                                                                                                                                                                                                                                               |                                                                                                                                        |                                                                                   |                          |
| 0.5 %                                                                                                                                                                                                                                                                                                                                                                                                            |                                                                                                                                        |                                                                                   |                          |
| Propriétés mécaniques - Condition 1                                                                                                                                                                                                                                                                                                                                                                              |                                                                                                                                        |                                                                                   |                          |
| Condition                                                                                                                                                                                                                                                                                                                                                                                                        | Limite d'élasticité Re                                                                                                                 | Contrainte à la rupture Rm                                                        | Allongement A (L0=5d0)   |
| u                                                                                                                                                                                                                                                                                                                                                                                                                | 690 (>= 550) MPa                                                                                                                       | 750 (640 - 820) MPa                                                               | 22 (>= 18) %             |
| Température 1                                                                                                                                                                                                                                                                                                                                                                                                    | Résilience 1 ISO-V KV                                                                                                                  | Remarques                                                                         |                          |
| -60 °C                                                                                                                                                                                                                                                                                                                                                                                                           | 60 (>= 47) J                                                                                                                           | u: untreated, as welded - shielding gas M21                                       |                          |
| Details welding consumables                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                        |                                                                                   |                          |
| CE                                                                                                                                                                                                                                                                                                                                                                                                               | CLASS AWS                                                                                                                              | CLASS EN ISO                                                                      | NORM AWS                 |
| X                                                                                                                                                                                                                                                                                                                                                                                                                | E90C-K3H4                                                                                                                              | T 55 6 1NiMo M M21 1 H5                                                           | AWS A5.28 / SFA-5.28     |
| NORM EN ISO                                                                                                                                                                                                                                                                                                                                                                                                      |                                                                                                                                        |                                                                                   |                          |
| EN ISO 18276-A                                                                                                                                                                                                                                                                                                                                                                                                   |                                                                                                                                        |                                                                                   |                          |