

Classifications			
EN ISO Norme A	EN ISO Classification A	AWS/SFA Norme A	AWS/SFA Classification A
EN ISO 17632-A	T 46 6 M M21 1 H5	AWS A5.18 / SFA-5.18	E70C-6M H4
Caractéristiques et domaines d'application			
Description courte	Caractéristiques principales	Applications	
Seamless metal cored wire for single- or multilayer welding of Carbon, Carbon-Manganese and similar types of steels, including fine grain steels with Argon-CO2 or pure 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 with post weld heat treatment. This wire is especially suitable for automated-robotized applications and for root pass welding for piping and butt-joints. This product can be used in sour gas applications. (HIC tested acc. to NACE TM-0284). Test values for SSC are available upon request	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 with post weld heat treatment	Especially suitable for automated-robotized applications and for root pass welding for piping and butt-joints. 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	
0.07 %	0.75 %	1.4 %	
Propriétés mécaniques - Condition 1			
Condition	Limite d'élasticité Re	Contrainte à la rupture Rm	Allongement A (L0=5d0)
u	500 (>= 460) MPa	600 (550 - 660) MPa	29 (>= 20) %
Température 1	Résilience 1 ISO-V KV	Température 2	Température 3
-60 °C	80 (>= 47) J	-50 °C	-40 °C
Résilience 3 ISO-V KV	Remarques		
120 J	u: untreated, as welded - shielding gas M21; u1: untreated, as welded - shielding gas C1; s: stress relieved 620°C / 2h - shielding gas M21		

Propriétés mécaniques - Condition 2

Condition	Limite d'élasticité Re	Contrainte à la rupture Rm	Allongement A (L0=5d0)
u1	460 ($\geq$ 420) MPa	560 (530 - 640) MPa	30 ($\geq$ 20) %
Température 1	Température 2	Résilience 2 ISO-V KV	Température 3
-60 °C	-50 °C	60 ($\geq$ 47) J	-40 °C
Résilience 3 ISO-V KV	Remarques		
80 J	u: untreated, as welded - shielding gas M21; u1: untreated, as welded - shielding gas C1; s: stress relieved 620°C / 2h - shielding gas M21		

Propriétés mécaniques - Condition 3

Condition	Limite d'élasticité Re	Contrainte à la rupture Rm	Allongement A (L0=5d0)
s	420 MPa	510 MPa	24 %
Température 1	Température 2	Température 3	Résilience 3 ISO-V KV
-60 °C	-50 °C	-40 °C	90 J
Remarques			
u: untreated, as welded - shielding gas M21; u1: untreated, as welded - shielding gas C1; s: stress relieved 620°C / 2h - shielding gas M21			

Details welding consumables

ABS	BV	CE	CLASS AWS
4Y H5	SA4YM HHH	X	E70C-6M H4
CLASS EN ISO	CWB	DB	DNV-GL
T 46 6 M M21 1 H5	X	X	V Y46MS(H5) / V Y46S H5 / IV YMS(H5)
LR	NORM AWS	NORM EN ISO	RINA
DXVud0-BF-5Y46S-H5-NA / D- BF-4Y42S-H5-NA	AWS A5.18 / SFA-5.18	EN ISO 17632-A	4Y S H5
TÜV			
X			