

Technical data sheet

EN131023GB

Cored welding wire

SPEEDARC T4**CLASSIFICATION**

ASME IIC SFA 5.20 / AWS A 5.20: E70T-4*
 EN ISO 17632-A: T 38 Z W NO 3*
 ASME IX Qualification: QW-432 F-N° 6 QW-442 A-N° 1
 *Elongation > 20% is not guaranteed

DESCRIPTION

- Self-shielded flux cored wire
- Single and multiple pass welding of CMn steels
- The arc is not affected by draughts or moderate wind
- High deposition rates in flat position
- Highly crack resistant deposits

APPLICATIONS

General fabrication applications on mild steel and CMn when high deposition rates are required without shielding gas and weld metal toughness is not the primary consideration. Typical applications include fabrication of machinery, earthmoving equipment, erection of steel framed buildings, welding of concrete reinforcement bars and heavy equipment repair.

Examples

Unalloyed construction steel	EN 10025	S185 to S355
Boiler plate	EN 10028-2	P235GH to P355GH
Fine-grained steels	EN 10113	S275 to S420
Pipe steels	EN 10208	L210 to L415
	API5LX	X42, X46, X52, X60
Shipbuilding steels	A, B, C, D, and A (H)	32 to D (H) 36
	ISO/TR 15608:	Groups 1.1 and 1.2

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Al
0.20	0.5	0.2	1.3

MINIMUM ALL-WELD MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]
490	390

TYPICAL ALL-WELD MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]
610	450

OPERATING CONDITIONS

Diameter [mm]	Stick-out [mm]	Current type	Current [A]	Voltage [V]
1.0	35 ± 10	DC+	90 - 250	19 - 27
1.2	40 ± 10		100 - 300	19 - 27
1.6	40 ± 10		150 - 280	19 - 27
2.0	50 ± 10		200 - 400	25 - 32
2.4	70 ± 10		300 - 500	26 - 34
2.8	70 ± 10		350 - 600	26 - 34
3.2	90 ± 10		350 - 700	28 - 38

WELDING POSITIONS

EN ISO 6947: PA, PB
 ASME IX: 1F, 1G, 2F

PACKAGING:

EN ISO 544:

Diameter	≤ 1.6 mm	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	Spool S 200	Spool BS 300	Coil B 450	Drum
Weight	5 kg	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.