

**Standards**

TS EN ISO 17632-A	: T 42 4 P C 1 H5
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AWS A5.20	: E 71T-1C-J

**Chemical Composition of  
Weld Metal (Typical)**

C	Si	Mn	P	S
0.06	0.5	1.3	0.015	0.015

**Mechanical Properties**

Heat Treatment	Yield Strength (N/mm <sup>2</sup> )	Tensile Strength (N/mm <sup>2</sup> )	Impact Strength (ISO-V/-40°C)	Elongation ((L <sub>0</sub> =5d <sub>0</sub> ) (%))
AW	min. 420	500- 640	min. 50 J	min. 22

AW: as welded

**Typical Base Material Grades**

- S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L360NB, L290MB L360MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

**Features and Applications**

- Rutile type flux-cored wire which is used for the production welding of machine and welding applications on ship, industry vehicle building and steel constructions in all positions
- Provides high mechanical properties, proper, smooth, X-ray safety seams
- It is economical as it has high melting ability and can work under high current in all positions
- Shielding gas: %100 CO<sub>2</sub>

**Welding Positions**

**Current Type**

FCAW / D.C. (+)

**Operating Data**

Product Code	Diameter (mm) / (inch)		Weight (Kg)	Package Type
	mm	inch		
3010500008	1.20	0.047"	4.5	D 200
3010500018	1.20	0.047"	15	D 300
3010500023	1.20	0.047"	15	BS 300
3010500020	1.60	0.062"	15	BS 300
3010500035	1.60	0.047"	200	BIG PACK

**Approvals:** ELCOR R71 (CO2): TL, DNV-GL, BV, ABS, LR, RS, DB NK, RINA, CE, TÜV, SEPRO