

Technical data sheet

011121MBA

Cored welding wire
ROBOFIL B 700**CLASSIFICATION**

ASME IIC SFA 5.29 / AWS A 5.29

E110T5-K4M-JH4

EN ISO 18276-A

T69 5 Mn2NiCrMo B M21 3 H5

ASME IX Qualification

QW-432 F-N° 6 QW-442 A-N° 12

DESCRIPTION

- Seamless high fill copper coated basic flux cored tubular wire for semi-automatic gas shielded arc welding
- Single and multipass welding of high strength steels
- Combines advantages of both seamless and seamed tubular wires
- Deposits have very low hydrogen contents. $H_{DM} < 4 \text{ ml/100g}$ deposited metal over the whole parameter box
- No moisture pick up, excellent wire feeding properties
- Excellent mechanical properties

APPLICATIONS

ROBOFIL B 700 is a basic flux cored wire with high ductility and cracking resistance for high strength fine grained construction steels. Tough at ambient temperatures and subzero temperatures, down to -50°C .

Examples

High strength steels

S500QL – S690QL

N-A-Xtra70, Weldox 700, HY80, HY100

T1, Superelso 700, Suprafort 700, Shoralsim 690

ISO/TR 15608: Groups 1.2, 1.3, 2.2 and 3.1

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo
0.05	1.4	0.4	0.3	2.4	0.5

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
770	690	16	-51°C : 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
850	760	20	-51°C : 60

SHIELDING GASEN ISO 14175: M21 (Ar + 15 - 25% CO₂)**OPERATING CONDITIONS**

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]
1.2	DC+ or pulsed	100 - 350	16 - 34	12 - 25
1.6	DC+ or pulsed	160 - 470	20 - 36	15 - 25

WELDING POSITIONS

ROBOFIL B 700 is primarily used in the flat and horizontal-vertical positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	BS300	
Weight	15 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.