Technical data sheet 011121MBA	Cored welding wire # ROBOFIL R Ni1SR	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.29 / AWS A 5.29	E81T1-Ni1M-JH4
EN ISO 17632-A	T50 6 1Ni P M 1 H5
EN ISO 17632-B	T556T1-1MAP-N2-UH5
ASME IX Qualification	QW-432 F-N° 6 QW-442 A-N° 10

DESCRIPTION

- Seamless high fill copper coated rutile cored wire for gas shielded metal arc welding
- Excellent toughness down to -60°C after stress relieving
- Single and multiple pass welding of cold tough steels
- High deposition rate welding can be carried out in all positions without the need to change parameters
- No moisture pick up, excellent wire feeding properties, good weldability and low spatter
- Extremely low hydrogen content
- For use with mixed gas

APPLICATIONS

Examples

Construction steels	EN 10025	S235JR to S355K2G4
Fine-grained steels	EN 10028-3	P275N, NH, NL1, NL2 to P460N, NH, NL1, NL2
	EN 10113	S275N to S460N, S275M to S460ML
Pressure vessel steels	EN 10028-2	P235GH to P355GH
Pipe steels	EN 10208	L240NB to L445NB
	API 5LX	X42, X46, X 52, X60, X65
Shipbuilding steels	A, B, D, E, A32/36 to F40	
	ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1	

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni
0.06	1.2	0.4	0.9

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
560	500	19	-60°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

	Rm [MPa]	Rp0.2% [MPa]	A_5 [%]	CVN [J]
As welded	610	550	25	-60°C: 90
S.R. 600°C / 6 h	580	510	27	-60°C: 50

SHIELDING GAS

M21 (Ar + 15 - 25% CO_2) gas mixtures according to EN ISO 14175

OPERATING CONDITIONS

Diameter [mm]	Current type	Amperage [A]	Voltage [V]	Stick out [mm]
1.2	DC+	180 - 330	22 - 34	15 ± 5
1.6	DC+	200 - 400	22 - 35	15 ± 5

WELDING POSITIONS

EN ISO 6947 & ASME IX: all positions.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us.