

**Technical data sheet**

011121MBA

**Cored welding wire****ROBOFIL R Ni2+****CLASSIFICATION**

ASME IIC SFA 5.29 / AWS A 5.29:	E81T1-Ni2M-JH4
EN ISO 17632-A	T 46 6 2Ni P M21 1 H5
EN ISO 17632-B	T55 6 T1-1 M21 A-N5-H5
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, especially in offshore applications
- 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 Ar – CO<sub>2</sub> gas mixtures

**APPLICATIONS****Examples**

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
	10Ni14, 12Ni14, 13MnNi6-3, 15NiMn6	
Pipe steels	EN 10208	L245NB to L415NB, L360QB to L450QB
	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	1.3	0.45	2.0

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
550	460	20	-60°C: 47

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**

Rm [MPa]	Rp0.2% [MPa]	A <sub>5</sub> [%]	CVN [J]
640	580	25	-60°C: 80

**SHIELDING GAS**EN ISO 14175: M21 (Ar + 15 - 25% CO<sub>2</sub>)**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 &amp; 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.

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.