

Technical data sheet <small>011121MBA</small>	Cored welding wire WA TUB CS 700	 Welding Alloys
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CLASSIFICATION

ASME IIC SFA 5.29 / AWS A 5.29:	E111T1-K3C
EN ISO 18276-A:	T 69 2 Z P C1 H5
ASME IX Qualification	QW-432 F-N° 6 QW-442 A-N° 10

DESCRIPTION

- All position rutile flux cored wire for gas shielded arc welding
- Nickel and molybdenum alloyed to improve sub-zero impact strength and tensile properties
- Single and multiple pass welding of high strength steels
- High deposition rate welding can be carried out in all positions without the need to change parameters
- For use with carbon dioxide

APPLICATIONS

Examples

High-strength steels	EN 10028-6	P690QH – P500Q – P690Q – P500QL1 – P690QL1
	EN 10025-6	S550Q – S620Q – S690Q – S650QL – S620QL – S690QL
Pipe steels	EN 10208	L555QB – L555MB – (X80)

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Mo	Ni	S	P
0.04	1.6	0.35	0.4	2.1	0.010	0.015

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
770	690	17	-20°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
830	760	23	-20°C: 70

SHIELDING GAS

EN ISO 14175: C1 (CO₂)

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]
1.2	DC+	120 - 340	23 - 30	15 ± 5
1.6	DC+	200 - 400	24 - 28	15 ± 5

WELDING POSITIONS

All positions.

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.