

**Technical data sheet**

011121MBA

**Cored welding wire****WA TUB CS 71C****CLASSIFICATION**

ASME IIC SFA 5.20 / AWS A 5.20: E71T-1C/1M  
 EN ISO 17632-A: T 46 0 P C1 1/T 46 0 P M21 1

ASME IX Qualification QW432 F-N° 6 QW442 A-N° 1

**DESCRIPTION**

- Gas shielded flux cored wire for semi-automatic or automatic welding of CMn steels
- Rutile, fast freezing slag for all positional welding
- Excellent welder appeal
- Suitable for welding root runs on ceramic backing
- Single and multiple pass
- For use with CO<sub>2</sub> or mixed gas

**APPLICATIONS**

Unalloyed or low-alloy construction steels, boiler plates, pipe steels, fine-grained steels and shipbuilding steels.

**Examples**

Unalloyed construction steels	EN 10025	S235JRG1 to S355J2G3
Boiler plate	EN 10028-2	P235GH to P355GH
Fine-grained steels	EN 10113	S275 to S420N, P275NL to P420NL
Pipe steels	EN 10208	L240NB to L415NB
	API 5LX	X42, X46, X52
Shipbuilding steels	A, E, A32 - F40	
	ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1	

**TYPICAL ALL-WELD METAL ANALYSIS [wt.%] – [CO<sub>2</sub> shielding gas]**

<b>C</b>	<b>Mn</b>	<b>Si</b>
0.04	1.2	0.5

**MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES – [CO<sub>2</sub> shielding gas]**

<b>Rm [MPa]</b>	<b>Rp 0.2% [MPa]</b>	<b>As [%]</b>	<b>CVN [J]</b>
530	460	20	0°C: 47

**TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES – [CO<sub>2</sub> shielding gas]**

<b>Rm [MPa]</b>	<b>Rp 0.2% [MPa]</b>	<b>As [%]</b>	<b>CVN [J]</b>
580	510	30	0°C: 100

**SHIELDING GAS**

C1 (CO<sub>2</sub>) or M21 (Ar + 15 - 25% CO<sub>2</sub>) according to EN ISO 14175

**OPERATING CONDITIONS**

<b>Diameter [mm]</b>	<b>Stick-out [mm]</b>	<b>Current type</b>	<b>Current [A]</b>	<b>Voltage [V]</b>
1.2	15 ± 5	DC+	140 - 340	24 - 36
1.6	15 ± 5		200 - 420	26 - 42

**WELDING POSITIONS**

All positions

**PACKAGING**

<b>Diameter</b>	<b>1.2 mm</b>	<b>1.6 mm</b>
	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.