

Technical data sheet

011121MBA

Cored welding wire**WA TUB CS MNi1****CLASSIFICATION**

ASME IIC SFA 5.28 / AWS A 5.28

E80C-Ni1 H4

EN ISO 17632-A

T50 6 1Ni M M21 1 H5

ASME IX Qualification

QW-432 F-N° 6 QW-442 A-N° 10

DESCRIPTION

- Seamless high fill copper coated metal-cored tubular wire for gas shielded metal arc welding
- 1% nickel alloyed to improve sub-zero impact strength
- Single and multipass welding of cold tough steels
- Optimal productivity by combining advantages of both seamless and seamed tubular wires
- H_{DM} guaranteed < 4 ml/ 100g deposited metal over the whole parameter box
- No moisture pick up, excellent wire feeding properties, good weldability and low spatter

APPLICATIONS

Construction steels	EN 10025	S235JR to S355K2G4
Fine-grained steels	EN 10028-3	P275N, NH, NL1, NL2 to P460N
	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
0.05	1.3	0.6	0.9

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
560	500	24	-60°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
610	540	27	-60°C: 80

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

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]
1.0	DC+ or pulsed	100 - 350	15 - 35	12 - 25
1.2	DC+ or pulsed	120 - 400	15 - 35	12 - 25
1.6	DC+ or pulsed	130 - 450	15 - 35	15 - 25

WA TUB CS MNi1 can be welded as well backhand (trailing) as forehand (pushing)

WELDING POSITIONS

WA TUB CS MNi1 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	1.0 mm	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

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