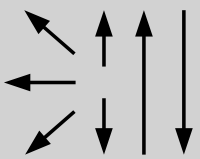


FCW Innershield

Flux cored wire, seamless, self-shielded, unalloyed

Classifications					
EN ISO 17632-A	EN ISO 17632-B	AWS A5.36	AWS A5.36M		
T46 Z Y N 1	T55T11-1N-H10	E71T11-AZ-CS3-H8	E491T11-AZ-CS3-H8		
Characteristics and typical fields of application					
<p>Self-shielded seamless flux cored wire designed for all position welding of low and medium alloyed steels. This wire is especially useful for on-site fabrication, structural or repair welding applications, single or multipass welding.</p> <p>Main features: good weldability, also vertical-up Position, good bead appearance, low spatter levels and easy to remove slag. The copper coated surface provides high resistance to rust and the seamless technology grants low moisture pick-up with low content of diffusible hydrogen levels (< H8).</p>					
Base materials					
<p>S235JR-S355JR, P355N, P195TR1-P265TR1, L210GA-L360 GA, L245NB-L415NB, L450QB, L245MB-L450MB</p> <p>ASTM A 106 Gr. A, B; A 181 Gr. 60; A 283 Gr. A; A 285 Gr. A, B; A 414 Gr. A, B; A 501 Gr. B; A 516 Gr. 55, 60; A 573 Gr. 55, 58; A 588 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65</p>					
Typical analysis of all-weld metal (wt.-%)					
	Gas	C	Si	Mn	Al
wt-%	-	0.25	0.40	1.00	1.50
Mechanical properties of all-weld metal					
Condition	Yield strength R_e	Tensile strength R_m	Elongation A ($L_0=5d_0$)		
	MPa	MPa	%		
u	530 (≥ 460)	640 (550–660)	24 (≥ 20)		
u untreated, as welded					
Operating data					
		Polarity: DC (–)	ø (mm) 0.9 1.2		
Welding with standard GMAW power source possible					
Approvals					
CE					