

LOW ALLOY**GAS-SHIELDED FLUX-CORED WIRES (FCAW/MCAW)**

An all-positional rutile cored wire for welding high strength steel with a minimum yield strength of 690 MPa for use with M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E111T1-K3MJ-H4 EN ISO 18276-A : T 69 4 2NiMo P M21 2 H5
Approvals	CE : EN 13479 UKCA : EN 13479 VdTÜV : 10733

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	Low Alloy (Ni Mo)
Shielding Gas	M21 (EN ISO 14175)

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	761 MPa	840 MPa	20 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-40 °C	60 J

Typical Weld Metal Analysis %				
C	Mn	Si	Ni	Mo
0.055	1.21	0.39	2.3	0.4

Deposition Data				
Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	21-32 V	5.6-19.8 m/min	2.1-7.5 kg/h