

Dual Shield 55

An all-positional rutile cored wire for welding steels with a minimum yield strength of 550 MPa, for use with M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.29 : E91T1-GM21 SFA/AWS A5.29 : E91T1-Ni1M21 EN ISO 18276-A : T 55 4 Z P M21 2 H5
Approvals	ABS : 4YQ500 SA H5 CE : EN 13479 UKCA : EN 13479

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

Welding Current	DC+
Diffusible Hydrogen	< 5 ml/100g
Alloy Type	Low alloy steel (<1% Ni)
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	604 MPa	663 MPa	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-40 °C	106 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.05	1.45	0.41	0.95

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	100-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h