Dual Shield 62

An all-positional rutile cored wire for welding steels with a minimum yield strength of 620 Mpa, for use with M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E101T1-G EN ISO 18276-A : T 62 4 Mn1.5Ni P M21 2 H5
Approvals	NAKS/HAKC : 1.2 mm

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

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

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 shielding gas			
As Welded	670 MPa	740 MPa	24 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
M21 shielding gas		
As Welded	-40 °C	95 J

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Ni**
M21 shielding gas			
0.061	1.58	0.41	1.50

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