

Corofil R56XL

A multi-purpose all positional rutile cored wire for use with carbon dioxide or argon /15-25% carbon dioxide shielding gas. Suitable for all positions except vertical down

Specifications

Classifications	SFA/AWS A5.20 : E71T-1C SFA/AWS A5.20 : E71T-1M EN ISO 17632-A : T 46 2 P C1 1 H5 EN ISO 17632-A : T 46 2 P M21 2 H5
Approvals	ABS : 3YSA H5 BV : SA3YM (M21) CE : EN 13479 DNV-GL : III YMS LR : 3YM H5 LR : 3YS H5 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	CMn steel
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
As Welded	497 MPa	588 MPa	27 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-20 °C	110 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
M21 shielding gas									
0.050	-	0.54	0.010	0.012	0.03	0.03	0.01	0.03	0.03
C1 shielding gas									
0.050	1.30	0.54	0.010	0.012	0.03	0.03	0.01	0.03	0.03

Typical Weld Metal Analysis %

Nb									
M21 shielding gas									
0.01									
C1 shielding gas									
0.01									

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	110-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h