Corofil R59Ni

An all-positional rutile cored wire for use with argon / 15-25% carbon dioxide shielding gas, providing very good toughness down to -40 °C. Can be used in all positions except vertical down.

Specifications	
Classifications	SFA/AWS A5.29 : E81T1-Ni1M EN ISO 17632-A : T 46 3 1Ni P C1 2 H5 EN ISO 17632-A : T 46 4 1Ni P M21 2 H5
Approvals	ABS : 3YSAH5 (M21) BV : SA3YM (M21) CE : EN 13479 DNV-GL : IV Y46MS H5 (M21) LR : 4Y46S H5 (M21) UKCA : EN 13479

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

Welding Current	DC+
Diffusible Hydrogen	< 5ml/100g
Alloy Type	Low alloy steel (1% Ni)
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 shielding gas			
As Welded	560 MPa	600 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
M21 shielding gas		
As Welded	-20 °C	130 J
As Welded	-30 °C	120 J
As Welded	-40 °C	110 J

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