

MILD STEEL**GAS-SHIELDED FLUX-CORED WIRES (FCAW/MCAW)**

A high fill downhand rutile cored wire for high speed welding using either C1 or M21 shielding gas.

Specifications	
Classifications	SFA/AWS A5.29 : E70T1-GC H8 SFA/AWS A5.29 : E70T1-GM H8 EN ISO 17632-A : T 42 2 1Ni R C1 3 H10 EN ISO 17632-A : T 46 2 1Ni R M21 3 H10
Approvals	ABS : 3SA, 3YSA H10 BV : S3YM HH (C1) BV : S3YM HH (M21) CE : EN 13479 DB : 42.105.18 DNV : III Y40MS (H5) (C1) DNV : III Y40MS (H10) (M21) LR : 3YS H10, 3YM H10 UKCA : EN 13479 VdTÜV : 07668

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

Welding Current	DC+
Alloy Type	Low alloy (<1% Ni)
Shielding Gas	M21, C1 (EN ISO 14175)

Tensile Properties			
Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	490 MPa	560 MPa	26 %
C1 shielding gas			
As Welded	465 MPa	540 MPa	27 %

Charpy Testing		
Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-20 °C	97 J
C1 shielding gas		
As Welded	-20 °C	78 J

Typical Weld Metal Analysis %				
C	Mn	Si	S	Ni
Shielding Gas M21				
0.052	1.04	0.53	0.019	0.70

Deposition Data				
Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.6 mm	250-450 A	26-40 V	6.5-19.1 m/min	4.0-12.1 kg/h