

Coreweld 46 LT H4

A metal cored wire designed for welding with Ar/CO₂ shielding gas mixture and for the welding of high strength steels with a minimum yield of 460MPa. Providing a very tough weld metal even down to low temperatures such as -60 degrees C.

Specifications

Classifications	SFA/AWS A5.28 : E80C-G H4 EN ISO 17632-A : T 46 6 Z M M21 2 H5
Approvals	ABS : 5YQ460 H5 BV : S5Y46M H5 CE : EN 13479 DB : 42.039.46 DNV-GL : V Y46MS H5 LR : 5Y46S H5 UKCA : EN 13479 VdTÜV : 19850

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21			
As Welded	520 MPa	610 MPa	
PWHT 2 hour(s) 620 °C	495 MPa	598 MPa	31 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21		
As Welded	-60 °C	94 J
PWHT	-60 °C	91 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas.			
0.061	1.46	0.57	0.55

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	90-380 A	14-35 V	2.0-18.5 m/min	1.0-8.9 kg/h
1.4 mm	105-390 A	14-34 V	1.6-12.0 m/min	1.0-8.0 kg/h