

Coreweld 46 LS

A metal cored wire which gives a very low amount of silica on the weld surface. Designed for welding thin plate (>1mm) as well as thicker sections with argon / carbon dioxide shielding gas. The wider welding arc produced means larger gaps can be bridged than with solid wire.

Specifications

Classifications	SFA/AWS A5.18 : E70C-6M H4 EN ISO 17632-A : T 46 4 M M20 2 H5 EN ISO 17632-A : T 46 4 M M21 2 H5
Approvals	ABS : 4Y400M H5 BV : 4Y40 H5 (M20 & M21) BV : 4Y40 H5 CE : EN 13479 DB : 42.039.38 DNV : IV Y40MS(H5) (M20 & M21) DNV : IV Y40MS(H5) NAKS/HAKC : 1.2mm UKCA : EN 13479 VdTÜV : 12152

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

Welding Current	DC+
Diffusible Hydrogen	< 4 ml/100g
Alloy Type	C Mn steel
Shielding Gas	M20, M21 (EN ISO 14175)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
As Welded	485 MPa	545 MPa	29 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
As Welded	-40 °C	72 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.04	1.25	0.63	0.35

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	100-360 A	16-32 V	1.8-13.0 m/min	1.3-8.0 kg/h
1.4 mm	150-380 A	18-34 V	2.5-9.0 m/min	1.8-7.0 kg/h
1.6 mm	150-450 A	17-36 V	2.0-9.3 m/min	1.7-7.8 kg/h