

Dual Shield 62

An all-positional rutile cored wire for welding steels with a minimum yield strength of 620 Mpa, for use with M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.29 : E101T1-G EN ISO 18276-A : T 62 4 Mn1.5Ni P M21 2 H5
Approvals	NAKS/HAKC : 1.2 mm

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

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

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	670 MPa	740 MPa	24 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-40 °C	95 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
M21 shielding gas			
0.061	1.58	0.41	1.50

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.2 mm	100-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h