Technical data sheet 150722MBA	Cored welding wire # ROBOFIL B Ni1	Welding Alloys

CLASSIFICATION

ASME IIC SFA 5.29 / AWS A 5.29	E80T5-GM-JH4
EN ISO 17632-A	T 46 6 1Ni B M 3 H5
EN ISO 17632-B	T556T5-0MA-N3-UH5

DESCRIPTION

- Seamless high fill copper coated basic flux cored tubular wire for semi-automatic gas shielded arc welding
- 1% nickel alloyed to improve sub-zero impact strength
- Single and multiple pass welding of cold tough / fine-grained steels
- Optimal productivity by combining advantages of both seamless and seamed tubular wires
- H_{DM} guaranteed < 4 ml/ 100g deposited metal over the whole parameter box
- No moisture pick up, excellent wire feeding properties, good weldability and low spatter

APPLICATIONS

Fine-grained, cold tough (down to -60°C) and high yield strength steels (up to 550 MPa)

Examples

Construction steels	EN 10025	S235JR to S355K2G4
Fine-grained steels	EN 10028-3	P275N, NH, NL1, NL2 to P460N
	EN 10113	S275N to S460N, S275M to S460ML
Pressure vessel steels	EN 10028-2	P235GH to P355GH
Pipe steels	EN 10208	L240NB to L445NB
	API 5LX	X42, X46, X 52, X60, X65
Shipbuilding steels	A, B, D, E, A32/36 to F40	
	ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1	

APPROVALS

TÜV (10205.02)

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni
0.06	1.4	0.4	1.1

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp 0.2% [MPa]	A_5 [%]	CVN [J]
530	470	20	-60°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp 0.2% [MPa]	A_5 [%]	CVN [J]
600	520	24	-60°C: 80

SHIELDING GAS

EN ISO 14175: M21 (Ar + 15 - 25% CO_2)

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]
1.2	DC+ or pulsed	110 - 350	16 - 34	12 - 25
1.6	DC+ or pulsed	160 - 470	20 - 36	15 - 25

WELDING POSITIONS

EN ISO 6947:	PA, PB
ASME IX:	1G, 1F, 2F

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME IIC SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us