

Technical data sheet

150722MBA

Cored welding wire**ROBOFIL B NiMo****CLASSIFICATION**

ASME IIC SFA 5.29 / AWS A 5.29	E90T5-G H4
EN ISO 18276-A	T 55 6 1.5NiMo B M 3 H5
EN ISO 18276-B	T626T5-0MAP-N2M2-UH5
ASME IX Qualification	QW-432 F-N° 6 QW-442 A-N° 10

DESCRIPTION

- Seamless high fill copper coated basic flux cored tubular wire for semi-automatic gas shielded arc welding
- For 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
- Exceptional mechanical properties

APPLICATIONS

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

Examples

Fine-grained steels	EN 10137	S460 to S550Q, QL and MC
	EN 10113	S460N, NL, M and ML
Pipe steels	EN 10208	L445MB to L550MB
	ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1, 2.2 and 3.1	

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Ni	Mo
0.05	1.4	0.4	1.2	0.4

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
620	540	17	-60°C: 27

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

	Rm [MPa]	Rp0.2% [MPa]	A ₅ [%]	CVN [J]
As welded	680	600	24	-60°C: 55
Stess relieved	650	580	25	-60°C: 65

SHIELDING GAS

ISO 14175: M21 (Ar + 15 - 25% CO₂)

OPERATING CONDITIONS

Diameter [mm]	Current type	Current [A]	Voltage [V]	Stick-out [mm]
1.2	DC+ or pulsed	100 - 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

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.