

Classifications

EN ISO 17632-A:2008	: T50 6 1.5Ni P C 1 H5	AWS A5.29-10	: E81T1-K2C H4
EN ISO 17632-B:2008	: T55 6 T1-1CA-N3-U H5	AWS A5.36-12	: E81T9-C1A8-K2-H4
JIS Z 3313	: T55 6 T1-1CA-N3-U H5	KS D 7104	: YFL-C506R

Description

- It is designed for welding of 560MPa high tensile steel for low temperature service
- Typical applications include offshore structures, LNG and LPG carriers and storage tank
- Wire is a metal type of flux cored wire for all-position welding
- The weld metal contain about 1.5% Ni so, good impact value at low temperatures down to -60°C
- It feature good porosity resistance and easy slag removal and deposition rate is higher than a titania type

Welding positions**Polarity & shielding gas**

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Ni
CO ₂	0.03	0.45	1.50	0.012	0.009	1.50

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-60°C	
AWS A5.29	min. 470	550~690	min. 19	≥ 27		
EN ISO 17632-B	min. 460	550~740	min. 17		≥ 47	
Example	550	640	25	120	55	CO ₂

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- In order to prevent crack at low temperatures, preheat and maintain interpass temperature at 100~200°C

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		

Approvals

Shielding gas	ABS	BV	DNV	RS	LR	NK	KR
CO ₂	5YSA5Y400SAH5	5Y40SH5	^{IV} Y40MS(H5)	5Y40SH5	5Y40SH5	KSWL3GH5	L3SGH5