

## Flux cored wire

**Classification:** ASME / AWS A5.20 E71T-1C  
EN ISO 17632-A - T 42 0 P C 1 H10

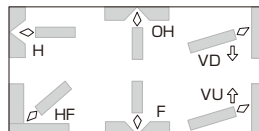
**Features:** • Soft and stable arc, less fume and spattering, smooth bead appearance, and good slag removal

**Type of flux:** Rutile

**Shielding gas:** CO<sub>2</sub>

**Polarity:** DC-EP

## Welding Positions:



## Chemical composition of all-weld metal (%) as per AWS

|          | C     | Si    | Mn    | P     | S     |
|----------|-------|-------|-------|-------|-------|
| Example  | 0.05  | 0.45  | 1.35  | 0.013 | 0.009 |
| Guaranty | ≤0.12 | ≤0.90 | ≤1.75 | ≤0.03 | ≤0.03 |

## Mechanical properties of all-weld metal as per AWS

|          | 0.2%OS<br>(MPa) | TS<br>(MPa) | EI<br>(%) | IV<br>(J) |
|----------|-----------------|-------------|-----------|-----------|
| Example  | 510             | 570         | 30        | -18°C: 85 |
| Guaranty | ≥400            | ≥490        | ≥22       | -18°C ≥27 |

## Recommended welding parameters

|        | 1.2mm    | 1.4mm    | 1.6mm    |
|--------|----------|----------|----------|
| Dia.   | 1.2mm    | 1.4mm    | 1.6mm    |
| F, HF  | 120~300A | 160~350A | 200~400A |
| H      | 120~280A | 160~320A | 200~350A |
| VU, OH | 120~260A | 160~270A | 200~280A |
| VD     | 200~300A | 220~300A | 250~300A |

## Approvals

| ABS                      | LR              | DNV         | BV                         | NK              | Others   |
|--------------------------|-----------------|-------------|----------------------------|-----------------|--|
| 2YSA,<br>2Y400SA,<br>H10 | 2YS,<br>2YM H10 | II YMS(H10) | SA2M, SA2YM,<br>SA2Y40M HH | KSW52Y40G(C)H10 | CR: 2YS-HH<br>GL: 2Y40H10S<br>KR: 2YSG(C)<br>CCS: 2SH10,<br>2YSH10 |

## Packages

| Dia.<br>(mm) | Type  | Weight<br>(kg) | Dia.<br>(mm) | Type  | Weight<br>(kg) | Dia.<br>(mm) | Type  | Weight<br>(kg) |
|--------------|-------|----------------|--------------|-------|----------------|--------------|-------|----------------|
| 1.2          | Spool | 12.5           | 1.4          | Spool | 15             | 1.6          | Spool | 15             |
|              | Spool | 15             |              | Spool | 20             |              | Spool | 20             |
|              | Spool | 20             |              | Pack  | 250            |              | Pack  | 350            |
|              | Pack  | 250            |              | Pack  | 350            |              |       |                |