

FCW 20

Metal Özlü Kaynak Teli - Non Alloyed Steels

Standards

AWS/ASME SFA - 5.18	E70C-GM H4
EN ISO 17632 - A	T46 3 M M 2 H5
TS EN ISO 17632 - A	T46 3 M M 2 H5

Materials

EN	DIN
S185 - S355J0	St 33- St 52.3
S255N - S420N	StE 255 - StE 420
P295GH	17Mn4
P235TR2 - P355T2	St 37.4 - St 52.4
P235G1TH, P255G1TH	St 35.8 - St 45.8
P235GH, P265GH	H I, H II
L210 - L415NB	StE 210.7 - StE 415.7
L290MB - L450MB	StE 290.7 TM - StE 445.7 TM
GE 200, GE 240	GS 38, GS 45
	AH 32, EH 36

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Akma Dayanımı (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)
As welded	M21	500	560	25	-30°C → 50

* Kimyasal kompozisyon ve mekanik özellikler koruyucu gazının kullanılması durumunda geçerlidir.

Application Information

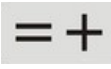
Welding Positions








Polarity:



Protection Gas:
M21

Welding Parameters & Efficiency

Diameter (mm)
1.20

Packaging Information

Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)	Packaging Type
3102005M15	1.20	15 KG	15.90	1	15.90	Plastic Spool (D300)

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.