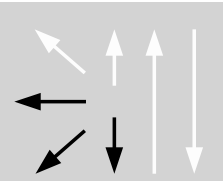


Classifications					
<b>EN ISO 17632-A</b>	<b>EN ISO 17632-B</b>	<b>AWS A5.36</b>	<b>AWS A5.36M</b>		
T46 Z M M 1 H5	T55ZT15-1MA H5	E70T15-M21AZ-CS1-H4	E490T15-M21AZ-CS1-H4		
Characteristics and typical fields of application					
<p>Seamless metal cored wire for singlelayer welding of galvanized, zinc coated or thin painted sheets (0.8 – 4 mm).            Features include: good weldability, excellent bead appearance and low spatter losses.            This wire is especially suitable for ship building, auto industry and manufacturing of air condition systems.</p>					
Base materials					
Galvanized steel sheets					
Typical analysis of all-weld metal (wt.-%)					
	Gas	C	Si	Mn	Al
wt-%	M21	0.30	0.30	1.10	1.80
Mechanical properties of all-weld metal					
Condition	Yield strength $R_e$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact work ISO-V KV J	
	MPa	MPa	%	-	
u	<b>550</b> ( $\geq 460$ )	<b>630</b> (530-680)	<b>24</b> ( $\geq 20$ )	-	
u untreated, as welded – shielding gas M21					
Operating data					
	<b>Polarity:</b> DC (–)	<b>Shielding gas:</b> (EN ISO 14175) M21	<b>ø (mm)</b>		
			1.0		
			1.2		
			1.4		
1.6					
Welding with standard GMAW-facilities possible					
Approvals					
CE					