

SAFDUAL 128V

MIG/MAG Cored Wires

High-strength steels

SAF-FRO

Closed-shape flux-cored wire electrode with rutile, fast-freezing slag for gas-shielded metal arc welding of unalloyed steels for operating temperatures from -50°C up to +450°C in all welding positions with spray arc featuring increased welding parameters and increased deposition rates. Very good slag removal, smooth seam surface without undercutting into the base metal. Very good mechanical property values and highly X-ray proof. Can be used in manual and fully-mechanised processes for example with orbital or vertical guiding device. Can be welded in all positions with one setting of parameters! Very well suited for use on ceramic weld pool backing. Used under mixed gas as shielding gas only (possible composition according to the corresponding scope of approval).

Rutile flux cored excellent weldability in all positions.
Ideal for offshore and shipyard applications in low temperature -40°C.

Classification

| | |
|-----|------------------------|
| AWS | A5.29: E91T1-GM |
| AWS | A5.36: E91T1-M21A6-Ni1 |

CE

Chemical analysis (Typical values in %)

| | C | Mn | Si | P | S | Ni |
|----------------|------|-----|-----|---------|---------|------|
| All weld metal | 0.05 | 1.3 | 0.4 | ≤ 0.015 | ≤ 0.015 | 0.85 |

All-weld metal Mechanical Properties

| Heat Treatment | Yield Strength (N/mm ²) | Tensile Strength (N/mm ²) | Elongation A5 (%) | Impact Energy ISO - V (J) |
|----------------|--|--|----------------------|---------------------------|
| | | | | -50 °C |
| As Welded | ≥ 550 | 620-760 | ≥ 22 | ≥ 50 |

Gas test: 82% Ar+18% CO₂

Shielding Gas - EN ISO 14175 : M21

Materials

S(P)235-S(P)460, GP240-GP280

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data

| Packaging Type | B300 |
|-----------------------|------------|
| Diam(mm) / weight(kg) | 16 |
| 1.2 | W000281158 |