SAFDUAL 128V

MIG/MAG Cored Wires

High-strength steels



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		

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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	Tensile Strength	Elongation	Impact Energy ISO - V (J)
	(N/mm²)	(N/mm²)	A5 (%)	-50 °C
As Welded	≥ 550	620-760	≥ 22	≥ 50

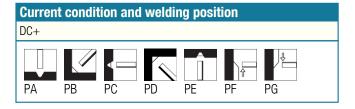
Gas test: 82% Ar+18% CO2

Shielding Gas - EN ISO 14175 : M21

Materials

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

Storage Keep dry and avoid condensation



Packaging data

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

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