## Key Facts

- Self shielded flux core wire
- Suitable for single pass applications
- Smooth arc action DC-
- No shielding gas required

## Description

Self-shielding, all-positional, flux-cored wire for single pass applications. Travel speed is high and weld edges are smooth. It has a smooth arc action, full slag coverage, easy slag removal with low spatter. No shielding gas is required.
The used of DC straight polarity welding current minimises the risk of burn through. Deposition efficiency is higher than that of shielded metal arc electrodes.

## Welding Positions

All positions

## Classification, Approvals & Conformances

AWS A5.20 E71T-GS
EN 758: T42 ZWN 1H 10

## Applications

Generally used in the repair of automotive parts such as cylinder heads, inlet manifolds and housings. Can also be used for defects and cast repairs.

- Excellent on galvanised steel
- General welding and repairs out doors
- Farm repairs and maintenance

## Typical Analysis/Composition

| C - Carbon | Mn - Manganese | Si - Silicon | Cr - Chromium |
|---|---|---|---|
| < 0.2 | 0.9 – 1.2% | < 0.45 | < 0.05 |
| **Ni-Nickel** | **Mo - Molybdenum** | **S - Sulphur** | **P - Phosphorus** |
| < 0.05 | <0.03 | <0.005 | <0.015 |
| **Cu - Copper** | **Ai - Aluminum** | | |
| < 0.03 | 0.4 – 1.2% | | |

## Typical Weld Mechanical Properties

| | |
|---|---|
| **0.2% Proof Stress:** | > 430 MPa |
| **Tensile Strength:** | >480 - 640 MPa |
| **Elongation (5xD):** | >22% |

## Packaging & Ordering Information

| Size | Weight | Part Number |
|---|---|---|
| 0.8mm | 0.9 Kg | 200342 |
| 0.8mm | 4.5 Kg | 200343 |
| 0.9mm | 0.9 Kg | 200344 |
| 0.9mm | 15 Kg | 200348 |
| 0.9mm | 4.5 Kg | 200345 |
| 1.2mm | 15 Kg | 200347 |
| 1.2mm | 4.5 Kg | 200346 |

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.