diamondspark X52 RC-Pipe

Flux cored wire, seamless, for automatic pipeline welding, rutile type

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.36	AWS A5.36M
T46 4 P M21 1 H5	T554T1-1M21A-H5	E71T1-M21A4-CS1-H4	E491T1-M21A4-CS1-H4

Characteristics and typical fields of application

Seamless rutile flux cored wire for single- or multilayer welding of Carbon, Carbon-Manganese steels and similar types of steels including fine grain steels with Argon-CO_2 shielding gas.

Main features: excellent weldability in all positions with high performance welding speed, very low spatter losses, good bead appearance, fast freezing and easy to remove slag. This wire is especially suitable for pipeline applications with automatic or semiautomatic welding equipment. Typical hydrogen value 2.5 – 3.5ml/100g weld metal.

Base materials

API 5L: X42,X46, X52, X56, X60
EN 3183: L290, L320, L360,L390, L415

Typical analysis of all-weld metal (wt.-%)

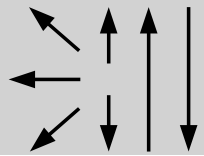
	Gas	C	Si	Mn
wt-%	M21	0.06	0.40	1.45

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	%	-20°C	-40°C
u	**500** (≥460)	**590** (550–660)	**26** (≥20)	**100**(≥47)	**60** (≥47)

u untreated, as welded – shielding gas M21 (Ar + 15 – 25 % CO_2)

Operating data



Polarity:	Shielding gases:	ø (mm)
DC (+)	(EN ISO 14175) M21: Ar + 15 – 25 % CO_2	1.2

Welding with standard GMAW power source possible

Approvals

TÜV, CE