

Cored Wires C-Mn and low-alloy steels

Cristal F208 is a new low fume seamless copper coated metal cored wire which generates less welding fume than similar standard products. It enables a fume emission rate reduction of up to 30 % (Standard shielding gas M21). Outstanding welding properties in the short-arc and spray-arc ranges. Almost splatter-free when welding in the spray-arc range. Good restriking, even with a cold wire tip, thus being suitable for robot applications. Characteristic features: high deposition rate and welding speed, good side wall fusion, finely rippled welds, without undercut into the base metal, even on contaminated or corroded metal surfaces. Little formation of silicates on the weld surface, so that multi-pass welds can be made without inter-run cleaning. Due to an easily controllable weld pool in the short-arc range, Cristal F 208 is well-suited for root-and positional welding and gap bridging.

Classification

AWS	A5.18: E70C-3MH4
EN	758: T 42 2 M M 1 H5

Approvals

Grades

BV
DNV
LRS
TÜV

see Appendix, Classification Society Approvals, for details pag. 521

Analysis of all-weld metal (Typical values in %)

C	Mn	Si	P	S	Cr	Ni	Mo	Nb	V	N	Cu
0.02	1.60	0.80	≤ -0.013	≤ 0.005	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
As Welded	≥ 420	510-600	≥ 24	≥ 50	-

Gas test: Acc. To EN 439: M21(Arcal 21-Atal 6)

Shielding Gas: Acc. To EN 439: M21(Arcal 21-Atal 6)

Materials

S(P)235-S(P)420

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg. 16

Diameters	1,2	1,4				
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