

Cored Wires C-Mn and low-alloy steels

Cristal F206 is a new low fume metal cored wire which generates less welding fume than standard products. It enables a fume emission rate reduction from 50% (Standard shielding gas M21) up to 80% (shielding gas M14). High current carrying capacity, almost spatter-free when welding in the spray-arc range. Good restriking, even with a cold wire tip, thus being suitable for robotic applications. Characteristic features: high deposition rate and welding speed, good side wall fusion, finely rippled welds, without undercut into the base metal, not 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 206 is well-suited for root- and positional welding and gap bridging.

Classification

AWS	A5.18: E70C-6MH4
EN	758: T 42 3 M M 1 H5

Approvals

Grades

BV
DB
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	1.50	0.80	-	-	-	-	-	-	-	-	-

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation A5 (%)	Impact Energy ISO - V (J) - 30 °C	Hardness
As Welded	≥ 420	510-610	≥ 26	≥ 65	-

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

Shielding Gas: Acc. To EN 439: M21(Arcal21-Atal6) or M14(Arcal 14)

Materials

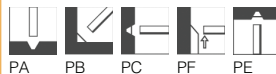
S(P)235-S(P)420

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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