

CRISTAL F119

Cored Wires C-Mn and low-alloy steels

Cristal F119 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 C1). Due to the easily controllable weld pool, the welding characteristics are outstanding. Weldable in all positions with only one setting of parameters (24 Volts, wire feed 9m/min, wire dia. 1,2 mm). The enhanced filling degree results in increased current carrying capacity and deposition rate, thus increasing welding speed and leading to a saving of time and costs. Low spatter loss, easy slag removal, smooth and finely rippled welds without undercut into the base metal.

Classification

AWS	A5.20: E71T-1H4
EN	758: T 46 2 P C 1 H5

Approvals

Grades

ABS
BV
DB
DNV
GL
LRS
RINA
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
0.03	1.50	0.50	-	-	-	-	-	-	-	-	-

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	≥ 460	550-650	≥ 22	≥ 55	-

Gas test: Acc. To EN 439: C1(Arcal 2)

Shielding Gas: Acc. To EN 439: C1(Arcal 2)

Materials

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

Shipbuilding steels A,B,D,E,AH32 to EH36

Storage

Keep dry and avoid condensation

Current condition and welding position

DC+



Packaging data: K300 kg, 16

Diameters	1,2	1,6				
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