

## Cored Wires C-Mn and low-alloy steels

Cristal F100 is a rutile 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). 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 and easy slag removal produce smooth and finely rippled welds without undercut into the base metal.

### Classification

AWS	A5.20: E71T-1 H4
EN	758: T 42 2 P C 1 H5

### Approvals

ABS
BV
DNV
GL
LRS

### Grades

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	0.60	-	-	-	-	-	-	-	-	-

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation A5 (%)	Impact Energy ISO - V (J) - 20 °C	Hardness
As Welded	≥ 420	510-610	≥ 24	≥ 50	-

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

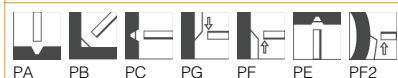
Shipbuilding steels A,B,D,E,AH32 to EH36

### Storage

Keep dry and avoid condensation

### Current condition and welding position

DC+



**Packaging data:** K300 kg. 16

Diameters	1,2					
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