

EN ISO 17632-A: T46 4 P M 1 H5
T46 2 P C 1 H5
EN ISO 17632-B: T555T1-1MA-H5
T553T1-1CA-H5
AWS A5.36: E71T1-M21A4-CS1-H4
E71T1-C1A2-CS1-H4
AWS A5.36M: E491T1-M21A4-CS1-H4
E491T1-C1A3-CS1-H4

BÖHLER Ti 52 T-FD

**Flux Cored Wire - Seamless, unalloyed
Rutile type**

Description

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-CO₂ shielding gas or pure CO₂. 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 removal. This wire is especially suitable for ship building, structural steel work or wherever good bead appearance is required.

Typical Composition of All-weld Metal

	Gas	C	Si	Mn
Wt-%	M21	0.05	0.35	1.25
Wt-%	C1	0.04	0.40	1.00

Mechanical Properties of All-weld Metal

	u	u1
Yield strength R _e MPa:	490 (≥460)	470 (≥460)
Tensile strength R _m MPa:	580 (550-660)	560 (550-660)
Elongation A (L ₀ =5d ₀) %:	28 (≥20)	25 (≥20)
Impact work ISO-V KV J	-20°C: 110	55 (≥47)
	-40°C: 60 (≥47)	

u = untreated, as welded – shielding gas M21
u1= untreated, as welded – shielding gas C1

Operating Data



re-drying: -
shielding gases: (EN ISO 14175) **M21-M35; C1**
welding with standard GMAW-facilities possible

ø mm

1,0
1,2
1,4
1,6



Base Materials

S235JR-S355JR, S235JO-S355JO, S450JO, S235J2-S355J2, S275N-S460N, S275M-S460M, P235GH-P355GH, P275NL1-P460NL1, P215NL, P265NL, P355N, P285NH-P460NH, P195TR1-P265TR1, P195TR2-P265TR2, P195GH-P265GH, L245NB-L415NB, L450QB, L245MB-L450MB, GE200-GE240
ship building steels: A, B, D, E, A 32-E 36

ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65

Approvals and Certificates

TÜV-D, DB, GL, DNV, ABS, LR, BV, RINA, RS, CE