

Corofil R56XL

Classifications Weld Metal

SFA/AWS A5.20	E71T-1C
SFA/AWS A5.20	E71T-1M
EN ISO 17632-A	T 46 2 P C 2 H5
EN ISO 17632-A	T 46 2 P M 2 H5

Description and applications

Corofil R56XL is an all-positional rutile flux-cored wire which gives spray transfer characteristics in the vertical and overhead positions. The wire may also be used for horizontal/vertical fillet welds and for downhand butt work. It is ideal for the general purpose welding of mild and carbon-manganese steels in all positions.

Approvals

ABS	: 3YSA H10 (M21)	DNV	: IIIYMS (M21) LR	3YS	(M21)
BV	: SA3YM (M21)				
CE	EN 13479				

Typical all-weld mechanical properties under shielding gas of 80 Ar/20 CO₂

Composition Wt %			Mechanical	As welded
	Min	Max		
C	0.02	0.08	YS	460 min N/mm ²
Si	0.30	0.80	UTS	530-660 N/mm ²
Mn	1.19	1.50	Elongation	22 min %
S		0.025	CVN at -20°C	54 min ave J
P		0.025		
Current range	DC + with shielding gas 15-20 l/min Ar/20%CO ₂ or CO ₂			
Size (mm)	1.2			
Current (amps)	110-300			