Corofil B55

Classifications Weld Metal

SFA/AWS A5.20	E71T1-5C H4
SFA/AWS A5.20	E71T1-5M H4
EN ISO 17632-A	T 42 3 B C 2 H5
EN ISO 17632-A	T 42 3 B M 2 H5

Description and applications

Corofil B55 is an easy to use basic flux-cored wire which deposits weld metal with a very low hydrogen content and with high resistance to cracking. Iron powder within the flux core results in high deposition rates and deposition efficiency of up to 90%. The slag is thin and easily removed. The 1.2mm diameter wire can be used in all positions. Corofil B55 is suitable for applications where good low temperature impact properties are required down to -30°C.

Approvals

CE EN13479	DB : 42.040.01 (M21 and C1)
LR : 3YS (M21)	VdTÜV : 04442

Typical all-weld mechanical properties under shielding gas of 80 Ar/20 CO_2

Composition Wt %

	Min	Max
C	0.03	0.10
Si	0.40	0.90
Mn	1.15	1.65
S		0.025
P		0.025

Mechanical	**As welded**	
YS	420 min	N/mm^2
UTS	530-640	N/mm^2
Elongation	22 min	%
CVN at -20°C	47 min ave	J
CVN at -30°C	47 min ave	J

Hydrogen < 10ml/100g

1.6mm diameter wire M21, 350 amps, 31 Volts DCEN

Current range	DC - with shielding gas of 15-20 l/min Ar/20%CO_2 or CO_2	
Size (mm)	1.2	1.6
Current (amps)	120-300	140-400