

## Coreweld 46 LT H4

A metal cored wire designed for welding with Ar/CO<sub>2</sub> shielding gas mixture and for the welding of high strength steels with a minimum yield of 460 MPa. Providing a very tough weld metal even down to low temperatures such as -60° C.

<b>Classifications Weld Metal</b>	SFA/AWS A5.28 : E80C-G H4 EN ISO 17632-A : T 46 6 Z M M21 2 H5
<b>Approvals</b>	ABS 5YQ460 H5 BV S5Y46M H5 CE EN 13479 DNV-GL V Y46MS(H5) LR 5Y46S H5

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	CMn

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>M21</b>			
PWHT 2hr 620°C	495 MPa	598 MPa	31 %
As Welded	520 MPa	610 MPa	-

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>M21</b>		
As Welded	-60 °C	94 J
PWHT 2hr 620°C	-60 °C	91 J

### Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.061	1.46	0.57	0.55

### Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	90-380 A	14-35 V	2.0-18.5 m/min	1.0-8.9 kg/h
1.4 mm	105-390 A	14-34 V	1.6-12.0 m/min	1.0-8.0 kg/h