

Coreweld 46 LS

Coreweld 46 LS is a new generation metal cored wire based on ESAB's revolutionary cored wire surface technology. It has been developed for the welding of thin-plate with a minimum thickness of 1.0 mm and provides fabricators with a substantially faster and higher quality welding solution to solid MAG wire. The absence or very low levels of silica on the weld surface and minimal spatter result in reduced post weld cleaning before coating/painting. Coreweld 46 LS is a unique product that markedly lowers the welding costs for mechanised and robotic fabrication.

The many advantages relative to solid wire are associated with the extremely wide spray arc parameter envelope that starts as low as 160A. With solid wire spray arc starts at around 200A for diameter 1.0 mm and 230A for diameter 1.2 mm. These features are valid for the standard shielding gas M21 (Ar + 15-25% CO₂), although optimal results are obtained in 92% Ar + 8% CO₂ mixtures. Switching from solid wire to Coreweld 46 LS will in most cases, require no change in the positioning of the welding gun so the conversion time is limited to the optimisation of welding parameters.

Metallo saldato - Classificazioni	SFA/AWS A5.18 : E70C-6M H4 EN ISO 17632-A : T 46 4 M M20 2 H5 EN ISO 17632-A : T 46 4 M M21 2 H5
Approvazioni	ABS 4Y40M H5 (M20 & M21) BV 4Y40 H5 (M20 & M21) CE EN 13479 DB 42.039.38 DNV IV Y40MS(H5) (M20 & M21) GL 4Y40H5S (M20 & M21) NAKS/HAKC 1.2MM VdTUV 12152

Le approvazioni si basano sulla localizzazione della fabbrica. Contatta ESAB per maggiori informazioni.

Corrente di saldatura	DC+
Idrogeno diffusibile	< 4 ml/100g
Tipo di lega	C Mn steel

Proprietà tensili tipiche

Stato	Resistenza allo snervamento	Resistenza alla trazione	Allungamento
Come saldato	485 MPa	545 MPa	29 %

Proprietà prova Charpy con intaglio a V

Stato	Temperatura di prova	Valore tenacità
Come saldato	-40 °C	72 J

analisi tipica del deposito

C	Mn	Si	Ni
0.04	1.25	0.63	0.35

Dati deposito

Diametro	Amp	Volt	Velocità di trascinamento del filo	Tasso di deposito
1.2 mm	100-360 A	16-32 V	1.8-13.0 m/min	1.3-8.0 kg/h
1.4 mm	150-380 A	18-34 V	2.5-9.0 m/min	1.8-7.0 kg/h
1.6 mm	150-450 A	17-36 V	2.0-9.3 m/min	1.7-7.8 kg/h