BÖHLER Q Ni1 RC (C1)

Rutile flux cored wire, low alloyed

Classification

AWS A5.29	EN ISO 17632-A
E81T1-Ni1C-H8	T46 4 1Ni P C1 1 H10

Characteristics and typical fields of application

BÖHLER Q Ni1 RC (C1) is a rutile flux cored wire and designed for all-position welding with excellent CVN impact properties in as welded condition at - 40°C.

Excellent welding characteristics in all positions. Very good mechanical properties, easy slag removability, low spatter level, smooth and good weld beads with X-ray-quality. Applicable in all position welding, with higher productivity and less time for post weld cleaning. Applicable for Single pass & multi passes weld.

Suitable for Butt, fillet welding of 490N/mm2 class high strength steel and low temperature steel of structure such as ships, bridges, buildings and storage tanks etc..

Base materials

S 235JR, S275JR, S355JR, S460M, (st 33, st37-2, st44-2, st52-3), P235 GH, P265GH, API 5L X42 –X 70, AH 32, DH 36, EH-36, EQ 43, A 40-F40, SA 516- Gr60, Gr 0 …etc

Typical analysis of all-weld metal (wt.-%)

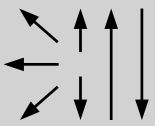
	Gas	C	Si	Mn	Ni
Wt-%	C1	0.055	0.38	1.25	0.90

Mechanical properties of all-weld metal

Condition	Yield strength R_e	Tensile strength R_m	Elongation A (L_0=5d_0)	Impact work ISO-V KV J
	MPa	MPa	%	-40°C
u	540 (≥ 470)	600 (575 – 690)	25 (≥ 19)	100 (≥ 47)

u untreated, as welded – shielding gas C1

Operating data



Shielding gas	Polarity	ø (mm)	Wire feed (m/min)	Current (A)	Voltage (V)
M21	DC (+)	1.2 1.6	6.0 – 15.0	120 – 280 160 - 400	24 – 32 24 - 34

Approvals

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