

PRODUCT DATA SHEET

BI2I T5 K4



Low hydrogen cored wire for welding CrNiMo low alloy steels used in the construction of earth moving machines, overhead travelling cranes, jib cranes and structures requiring high mechanical properties. Easily removable slags. Very good efficiency.

Classifications

AWS	A5.29	EI2IT5-K4
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Chemical Analysis

% Carbon	0,07	% Sulphur	0,012
% Manganese	1,4	% Chromium	0,55
% Silicon	0,5	% Nickel	2,0
% Phosphorous	0,012	% Molybdenum	0,4

Typical Mechanical Properties (All weld metal)

Tensile Strength	875 MPa
0,2% Proof Stress	775 MPa
% Elongation on 5d	18
Charpy V-Notch at -20°C	90 J
Charpy V-Notch at -40°C	65 J

Packing Data (DC-)

Diameter (mm)	Current		Stick Out (mm)	Pack Mass (kg)	Item Number
	Amps (A)	Volts (V)			
1,2	110 - 340	16 - 34	15 - 20	15,0	W078200

Suggested gas for FCW welding: Fluxshield®

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