

# diamondspark 31 NG

Flux cored wire, seamless, self-shielded, unalloved

CI						

EN ISO 17632-A EN ISO 17632-B AWS A5.20 / SFA-A5.20
T 42 Z Y NO 1 H10 T 49 T11-1NO-H10 E71T-11

### Characteristics and typical fields of application

Self-shielded seamless flux cored wire designed for all position welding of low and medium alloyed steels. This wire is especially useful for on-site fabrication, structural or repair welding applications, single or multipass welding, generally not recommended for the welding of materials over 20 mm thickness.

Main features: good weldability, also vertical-up Position, good bead appearance, low spatter levels and easy to remove slag. The copper coated surface provides high resistance to rust and the seamless technology grants low moisture pick-up with low content of diffusible hydrogen levels (< H8).

#### **Base materials**

S235JR-S355JR, P355N, P195TR1-P265TR1, L210GA-L360 GA, L245NB-L415NB, L450QB, L245MB-L450MB
ASTM A 106 Gr. A, B; A 181 Gr. 60; A 283 Gr. A; A 285 Gr. A, B; A 414 Gr. A, B; A 501 Gr. B; A 516 Gr. 55, 60; A 573 Gr. 55, 58; A 588 Gr. A;
API 5 L Gr. B, X42, X52, X56, X60, X65

Typical analysis					
	Gas	C	Si	Mn	Al
wt%	-	0.25	0.40	1.00	1.50

### Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R <sub>p0.2</sub>	Tensile strength R <sub>m</sub>	Elongation A (L <sub>0</sub> =5d <sub>0</sub> )	
	Мра	Мра	%	
u	440 (≥420)	600 (500-640)	24 (≥22)	

## u untreated, as welded

### **Operating data**



Polarity	DC-	Dimension mm
Shielding gas (EN ISO 14175)	NO GAS	1.0
		1.2
		1.4
		1.6

welding with standard GMAW power source possible

#### **Approvals**

CE