Coreweld 46 LS

A metal cored wire which gives a very low amount of silica on the weld surface. Designed for welding thin plate (>1mm) as well as thicker sections.with argon / carbon dioxide shielding gas. The wider welding arc produced means larger gaps can be bridged than with solid wire.

Specifications	
Classifications	SFA/AWS A5.18 : E70C-6M H4 CSA W48 : E491T15-M20A5-CS1-H4 CSA W48 : E491T15-M21A5-CS1-H4 EN ISO 17632-A : T 46 4 M M20 2 H5 EN ISO 17632-A : T 46 4 M M21 2 H5
Approvals	ABS : 4Y400M H5 BV : SA4Y40 H5 CE : EN 13479 CWB : E491T15-M20A5-CS1-H4 E491T15-M21A5-CS1-H4 DB : 42.039.38 DNV : IV Y40MS(H5) (M20 & M21) UKCA : EN 13479 VdTÜV : 12152

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

Welding Current	DC+
Diffusible Hydrogen	< 4 ml/100g
Alloy Type	C Mn steel
Shielding Gas	M20, M21 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
As Welded	485 MPa	545 MPa	29 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
As Welded	-40 °C	72 J

Typical Weld Metal Analysis %			
C	**Mn**	**Si**	**Ni**
0.04	1.25	0.63	0.35

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
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