

## Corofil R56XL

A multi-purpose all positional rutile cored wire for use with carbon dioxide or argon /15-25% carbon dioxide shielding gas. Suitable for all positions except vertical down

<b>Classifications</b>	SFA/AWS A5.20 : E71T-1C SFA/AWS A5.20 : E71T-1M EN ISO 17632-A : T 46 2 P C1 1 H5 EN ISO 17632-A : T 46 2 P M21 2 H5
<b>Approvals</b>	ABS : 3YSA H5 BV : SA3YM (M21) CE : EN 13479 DNV-GL : III YMS LR : 3YS H5

<b>Welding Current</b>	DC+
<b>Diffusible Hydrogen</b>	< 5 ml/100g
<b>Alloy Type</b>	CMn steel

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>C1 shielding gas</b>			
As Welded	497 MPa	588 MPa	27 %

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>C1 shielding gas</b>		
As Welded	-20 °C	110 J

### Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
<b>M21 shielding gas</b>									
0.050	-	0.54	0.010	0.012	0.03	0.03	0.01	0.03	0.03
<b>C1 shielding gas</b>									
0.050	1.30	0.54	0.010	0.012	0.03	0.03	0.01	0.03	0.03

### Typical Weld Metal Analysis %

<b>Nb</b>									
<b>M21 shielding gas</b>									
0.01									
<b>C1 shielding gas</b>									
0.01									

### Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	110-300 A	21-32 V	3.2-14.5 m/min	1.3-5.8 kg/h