

diamondspark 52 RC

Flux cored wire, seamless, unalloyed, rutile type



MADE IN

U. S. A.

Classifications			
EN ISO 17632-A	EN ISO 17632-B	AWS A5.36M/SFA-5.36	AWS A5.20/SFA-5.20
T46 4 P M21 1 H5	T555T1-1MA-H5	E71T1-M21AP5-CS2-H4	E71T-1M / T-9M/T-12M JDH4
T46 2 P C 1 H5	T553T1-1CA-H5	E71T1-C DH41A4 CS2	E71T-1C / T-9C/T-12C DH4

Characteristics and typical fields of application

Seamless rutile flux cored wire for single- or multilayer welding of Carbon, Carbon-Manganese steels and similar types of steels including fine grain steels with Argon-CO₂ shielding gas or pure CO₂. Main features: excellent weldability in all positions with high performance welding speed, very low spatter losses, good bead appearance, fast freezing and easy to remove slag. This wire is especially suitable for ship building, structural steel work or wherever good bead appearance is required. Typical hydrogen value 2.5 – 3.5ml/100g weld metal.



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Base materials

ASTM A 106 Gr. A, B, C; A 181 Gr. 60, 70; A 283 Gr. A, C; A 285 Gr. A, B, C; A 350 Gr. LF1; A 414 Gr. A, B, C, D, E, F, G; A 501 Gr. B; A 513 Gr. 1018; A 516 Gr. 55, 60, 65, 70; A 573 Gr. 58, 65, 70; A 588 Gr. A, B; A 633 Gr. C, E; A 662 Gr. B; A 711 Gr. 1013; A 841 Gr. A; API 5 L Gr. B, X42, X52, X56, X60, X65

Typical analysis of all-weld metal

	Gas	C	Si	Mn
wt-%	M21	0.06	0.40	1.45
	C1	0.04	0.35	1.25

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

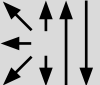
Condition	Yield strength	Tensile strength	Elongation A ($L_0=4d_0$)	Impact values CVN [ft.lb]		
				-20 °F	-40 °F	-40 °F
	ksi	ksi	%			
u	73 (≥ 58)	86 (70-95)	26 (≥ 20)	55 (> 20)	52 (> 20)	37 (> 20)
u ¹	68 (≥ 58)	81 (70-95)	28 (≥ 20)	44 (> 20)	35 (> 20)	-
s ¹	74 (> 58)	86 (70-95)	26 (> 22)	-	-	30 (> 20)

u = untreated, as welded – shielding gas M21

u¹ = untreated, as welded – shielding gas C1

s¹ = stress relieved 1148F - 1 hour, shielding gas M21

Operating data

Welding positions	Polarity	Rebacking	Shielding gases	ø inch
	DC (+)	Not necessary when following the recommended storage conditions	M21 – M35; M21; C1 Argon + 5-25% CO ₂ or 100% CO ₂	0.045 0.052 1/16

Welding with standard GMAW power source possible.

Approvals

ABS, CWB, Seismic D1.8 Supplement

Article number	Size [inch]	Weight spool / drum	Weight pallet [lbs]	Packaging
43394	0.045	33 lb spool	2079	Plastic Spool / D300
43397	0.045	550 lb drum	2200	Drum
43408	0.052	33 lb spool	2079	Plastic Spool / D300
43416	0.052	550 lb drum	2200	Drum
43420	1/16	33 lb spool	2079	Plastic Spool / D300
43427	1/16	55 lb spool	1650	Plastic Spool / D25
43429	1/16	550 lb drum	2200	Drum

Country of origin: USA