PROLINE
professional welding supplies

LINCOLN ELECTRIC
THE WELDING EXPERTS

UltraFil™ RNi1M Seamless Flux Cored Wire

Key Features

- Premium copper coated gas shielded flux cored wire – excellent mechanical properties
- Seamless wire technology ensures hydrogen levels stay at H4/H5 levels even after long term storage
- Smooth spray transfer achieved at low welding current levels - minimal spatter
- Designed for use with mixed gas operation, Argon with 15-25% CO2
- Diffusible hydrogen typically 3 mls per 100gms deposited metal (per AWS A4.3)

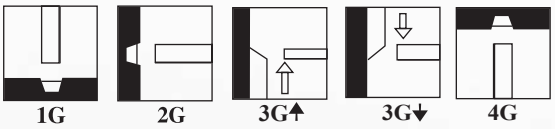
Typical Applications

- Full positional welding of low temperature higher toughness steels, low alloy medium to high strength steels, under matching the tensile strength of Q&T steels Eg: Bisplate 60/70/80, and weathering grade steels where colour match (patina), is not essential.
- Suitable for X65 pipe, where Ni content is kept below 1% to conform with NACE MR0175.
- General and high integrity structural steel fabrication, offshore constructions, oil and gas, bridges, pipe spooling, vessels, mining and mineral processing equipment such as dragline/shovel components and crusher/sizer components, architectural constructions, and other heavy equipment where high toughness steels are used.
- Suitable for fillet, butt and build-up welding applications

Conformances

AWS A5.29	E81T1-Ni1M-JH4
AWS A5.29M	E551T1-Ni1M-JH4
AWS A5.36	E81T1-M21A8-Ni1-H4 E81T9-M21A8-Ni1-H4
AWS A5.36M	E551T1-M21A6-Ni1-H4 E551T9-M21A6-Ni1-H4
AS/NZS ISO 17632-A	T 46 6 1Ni P M 1 H5
AS/NZS ISO 17632-B	T 55 6 T1-1 M A-N2-U H5

Welding Positions



Shielding Gas

- M21 shielding gases
- Flow Rate: 15 - 20 L/min

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UltraFil™ RNi1M

Seamless Flux Cored Wire

Diameter / Packaging / Part Number /Settings

Diameter mm	Plastic S300 Spool 15kg	WFS m/min	WFS in/min	Voltage volts	Approx Current amps	Deposition Rate (max)	ESO (Stickout)
1.2 1.6	P/N: 17-1216 P/N: 17-1616	5.1 - 12.7 3.6 - 8.9	200-500 140-350	23-30 21-31	180-300 235-400	5.4 kg/hr 5.9 kg/hr	20 ± 5mm

Polarity: DC Electrode Positive (DC+)

Typical Mechanical Properties

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -40°C	Charpy V-Notch J @ -60°C
Argon +20% CO_2	550	610	27	130	80

Typical Weld Composition / Diffusible Hydrogen Content

	%C	%Mn	%Si	%Ni	%P	%S	Diffusible Hydrogen
Argon +20% CO_2	0.05	1.28	0.33	0.90	0.010	0.003	3.0 mls / 100 gms

CUSTOMER ASSISTANCE POLICY

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