

Coreweld 55 LT H4

A metal cored wire for the welding of high strength steels (>550 MPa) with excellent sub-zero toughness down to -60 degree C and low diffusible hydrogen levels. Suitable for welding with Ar/CO₂ gas mixtures.

Specifications	
Classifications	SFA/AWS A5.28 : E90C-G H4 EN ISO 18276-A : T 55 6 Z M21 2 H5
Approvals	CE : EN 13479 UKCA : EN 13479

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
As Welded	595 MPa	670 MPa	25 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
As Welded	-60 °C	110 J

Typical Weld Metal Analysis %			
C	Mn	Si	Ni
0.05	1.65	0.44	1.35

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	100-320 A	16-32 V	1.8-12.0 m/min	1.3-7.5 kg/h
1.4 mm	120-380 A	16-34 V	2.0-9.0 m/min	1.6-7.5 kg/h
1.6 mm	140-450 A	18-36 V	1.5-8.5 m/min	1.6-8.0 kg/h