

Coreweld 69 LT H4

A metal cored wire for the welding of high strength steels (>690 MPa) with excellent sub-zero toughness down to -60 degrees C and low diffusible hydrogen levels. Suitable for welding with Ar/CO₂ gas mixtures.

Classifications Weld Metal	SFA/AWS A5.28 : E110C-G-H4 EN ISO 18276-A : T 69 6 Mn2NiMo M M21 2 H5 EN ISO 18276-B : T 76 6 T15 0M21A N4M2 U H5
Approvals	CE EN 13479

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

Welding Current	DC+
Diffusible Hydrogen	< 4ml/100g
Alloy Type	C Mn, low alloy steel (2% Ni, 0.5% Mo)
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
As Welded	755 MPa	790 MPa	20 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-60 °C	80 J

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
0.05	1.7	0.5	0.008	0.011	2.30	0.06	0.50	0.01	0.012

Typical Weld Metal Analysis %

Nb
0.005

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