

# Metalshield® Z

## CLASSIFICATION

AWS A5.18	: E70C-GS	A-Nr	1
EN ISO 17632-A	: T 3 T Z Z M M20 3	F-Nr	6
EN ISO 17632-B	: T 49 Z TG-0 M20 S A-G	9606 FM	1

## GENERAL DESCRIPTION

Metal cored wire for welding of Zn coated and mild steel

Designed to enhance productivity and quality of single pass lap and fillet welds on galvanized and other zinc coated steels (galvannealed)

Capable of welding with high travel with zero external porosity and less than 1% internal porosity

Developed for optimal performance with Rapid Z® Waveform Control Technology®

Reduces both external and internal weld metal porosity inherent to welding coated steel

Ideal for welding thin sheet material

## WELDING POSITIONS (ISO/ASME)



PA/1G



PB/2F



PC/2G

## CURRENT TYPE / SHIELDING GAS (ISO 14175)

DC +

M20 : Active gas 95-85%Ar + 5-15%CO<sub>2</sub>

Flow rate : 15-25 l/min

## CHEMICAL COMPOSITION (W%), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	P	S
M20	0.07-0.12	1.5-2.1	0.9-1.25	0.015 max	0.02 max

## MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )
Required:ISO 17632-B			min. 490
Typical values	M21	AW	570

## PACKAGING AND AVAILABLE SIZES

Diameter (mm)	0.9	1.0
15 kg spool B300	X	X
227 kg Accutrak® Drum	X	X

Metalshield® Z: rev. C-EN01-13/09/17