

PRODUCT DATA SHEET

Afrox TM-121



TM-121 is a versatile tubular wire with excellent operator appeal because of its smooth arc, low spatter and overall ease of handling. With no shielding gas needed, it is a good choice for welding in hard-to-reach locations or where the provision of gas cylinders is not practical. It is a good wire for applications where windy or other adverse conditions prevail and where mechanical properties are of less concern. TM-121 has little tendency to burn through and is well suited for butt,

fillet, and lap joints on steel thicknesses from 1,6-10 mm. It is not recommended for welding steel thicknesses greater than 12,7 mm. When welding on steels in the 10-19 mm thickness range, a preheat temperature of 160°C is advisable. The wire is recommended for single-pass and limited multiple-pass welding in all positions, using no shielding gas.

Classifications

AWS	A5.20	E71T-11
EN	17632-A	T 42 Z W N I H10

Approvals

American Bureau of Shipping E71T-11 (AWS A5.20)

Typical Chemical Analysis (All weld metal)

% Carbon	0,3	% Sulphur	0,003
% Manganese	0,49	% Phosphorous	0,009
% Silicon	0,15	% Aluminium	1,18

Typical Mechanical Properties (All weld metal using CO₂ gas)

Yield Strength	442 MPa
Tensile Strength	628 MPa
% Elongation on 50 mm	21

Welding Data (DC+)

Diameter (mm)	Position	Current		Optimum Settings		Deposition Rates (kg/h)	Electrode Stick Out (mm)
		Amps (A)	Volts (V)	Amps (A)	Volts (V)		
1,6	Flat/horizontal	125 - 300	19 - 20	230	17	0,5 - 3,3	12,0 - 19,0
1,6	Vertical/overhead	125 - 250	15 - 19	175	16	0,7 - 2,1	12,0 - 19,0
2,0	Flat/horizontal	175 - 350	16 - 22	275	19	1,1 - 3,0	12,0 - 19,0

Packing Data

Diameter (mm)	Pack Mass (kg)	Package	Item Number
1,6	15,0	Spool	W081013
2,0	15,0	Spool	W081015
2,0	22,0	Coil	W081014

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For more information contact the Afrox Customer Service Centre Tel: 0860 02 02 02
E-mail: customer.service@afrox.linde.com Website: www.afrox.com

