

Classifications

EN ISO 14171-A	AWS A5.17 / SFA-5.17
T3	EC1

Characteristics and typical fields of application

diamondspark S 55 HP is a coppered seamless basic flux cored wire with a good resistance to deformation and is very easy to straighten to ensure the best current transfer with a low contact tip wear. The wire is not sensitive to moisture pick up. The weld metal demonstrates good toughness properties at low temperatures, which gives the fabricator the possibility to weld with high heat-input at high welding speed resulting in very high productivity: e.g: single wire 3,2 mm, 800 Amps (~17 kg/hour) with a good bead appearance, nice fusion and good slag detachability. Suitable for tandem configuration (~ 30 kg/hour) with 2 wires (3,2 or 4,0 mm). 2-run technology can be applied with suitable fluxes. Mechanical properties depend of the applied welding procedure.

Typical fluxes to combine

Process	Name	EN ISO 14174
SAW	UV 306	S A AR 1 77 AC H5
SAW	UV 418 TT	S A FB 1 55 AC H5
SAW	UV 419 TT-W	S A FB 1 55 AC H5
SAW	UV 421 TT	S A FB 1 55 AC H5

Packaging

Size(s) in mm	Type	Weight
2,4	basket spool	25 kg
3,2	Spool	25 kg
4,0	spool	25 kg

Other sizes and coil weights on request.

