



**FCAW LOW ALLOY STEEL (High Strength)**  
**AUTOMIG FC 110T5-K4**

LOW ALLOY STEEL FCAW WIRE FOR Q&T HIGH STRENGTH STEELS



**CLASSIFICATION :** AWS A/SFA 5.29

EN ISO 18276-A

**APPROVALS :**

E110T5-K4C H4

T 62 5 Mn2NiCrMo B C 4 H5

IBR

**KEY FEATURES :**

- Basic type gas shielded FCW wire
- Stable arc, Easy slag removal
- Low fumes, Minimal spatters
- Smooth and porosity free weld
- Excellent low temperature toughness down to -50°C
- Suitable for high strength fine grained steels
- Radiographic quality weld

**WELDING POSITION :**



**DCEP**

| Shielding Gas   | Gas Flow Rate, LPM | Stickout, mm |
|-----------------|--------------------|--------------|
| CO <sub>2</sub> | 10-20              | 10-20        |

**TYPICAL APPLICATIONS :**

- Welding of high strength, quenched and tempered fine grained steels like N-A-XTRA 65 & 70, USST1, T1B, WELTEN 70C
- Welding of SA533/533M Gr. B/C/D Class 2 & 3, SA543/543M Gr.B/C Class 1 & 2, SA225/225M Gr.C/D, SA738/738M Gr.A/B/C

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :**

|               | C        | Mn        | Si       | Ni        | Cr        | Mo        | V        | S         | P         |
|---------------|----------|-----------|----------|-----------|-----------|-----------|----------|-----------|-----------|
| Specification | 0.15 max | 1.20-2.25 | 0.80 max | 1.75-2.60 | 0.20-0.60 | 0.20-0.65 | 0.03 max | 0.025 max | 0.025 max |

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

|               | Condition | UTS, MPa | YS at 0.2% offset, MPa | EL%    | CVN Impact at -50°C, J |
|---------------|-----------|----------|------------------------|--------|------------------------|
| Specification | As Welded | 760-900  | 680 min                | 15 min | 27 min                 |

Diffusible H<sub>2</sub> Content: <4 ml/100 gm

**PARAMETERS - PACKING DATA :**

| Ø, mm | Voltage, V | Amperage, A | Kg/Spool |
|-------|------------|-------------|----------|
| 1.2   | 22 - 30    | 130 - 300   | 15       |
| 1.6   | 24 - 32    | 200 - 380   | 15       |