



FCAW C-Mn STEEL
AUTOMIG FC 121

VACUUM PACKED FCAW WIRE FOR C-Mn STEEL STRUCTURAL FABRICATION



CLASSIFICATION : EN ISO 17632-A AWS A/SFA 5.20

T 42 2 R C 2 E71T-1C

APPROVALS : ABS/BV/DNV/IRS/LRA/NKK

KEY FEATURES :

- Rutile type gas shielded FCW wire
- Low fumes, least spatters
- Easy slag detachability, smooth welds
- High deposition rate than solid wire electrodes
- High quality single and multi pass welding
- Vacuum packed
- Radiographic quality weld

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO ₂	12-20	10-20

TYPICAL APPLICATIONS :

- Welding of structural and C-Mn steel with tensile strength up to 500 Mpa
- Steel structures, Bridges, Vehicles
- Shipbuilding, Towers, Cranes
- Machinery parts, Steel frames
- Rolling stocks, Hulls
- Chemical plant machinery
- General carbon steel fabrication
- Suitable for joining P.No.1 type ASTM SA 36/36M, SA 285/285M Gr.A/B/C, SA 414/414M Gr.A/B/C/D

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	S	P
Typical	0.06	1.4	0.4	0.01	0.01
Specification	0.10 max	0.90-1.75	0.90 max	0.030 max	0.030 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C, J
Typical	As Welded	500-640	460	27	90
Specification		500 min	420 min	22 min	47 min

Hardness, 3 Layer: 200 BHN max

PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	21 – 28	130 - 300	15
1.6	25 – 32	200 - 380	15

EQUIVALENT :

SMAW Electrode: **Supabase, Supabase X Plus**

GMAW Wire: **Automig 70S-6**