



AUTOMIG FC 18M SPL

FCAW LOW ALLOY STEEL (High Strength)

AWS A/SFA 5.29 **E91T1-D1C**

CLASSIFICATION:

EN ISO 18276-B
T 624T1-1CA-3M2

KEY FEATURES:

- Rutile type gas shielded FCW wire
- Stable and smooth arc
- Low fumes, Minimal spatters
- Easy slag removal, smooth weld bead
- Specially designed to produce weld with high tensile strength and moderate impact toughness
- All position capability
- Radiographic quality weld

APPROVALS: RDSO Class III/CE

TYPICAL APPLICATIONS:

- Welding of High Tensile Steels like IS 8500 Gr.540B, 570B and 590B, IS 2002 Gr.III, IS 1875 CL IIIA
- Welding of SAILMA 450/450HI steel used in CONCOR wagons is a typical application for this wire


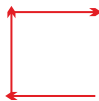
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Mo
0.08	1.40	0.5	0.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -40°C, J
Specification	As Welded	620-760	540 min	17 min	27 min

PARAMETERS - PACKING DATA:

∅, mm	Net Wt, Kg		
1.2	15	 DCEP STORAGE / HANDLING : Keep dry and follow handling instructions mentioned on the box	All Positions, Except Vertical Down 
1.6	15		

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20