



FCAW LOW ALLOY STEEL (High Strength)
AUTOMIG FC 18M SPL

FCAW WIRE FOR HIGH STRENGTH STEEL



CLASSIFICATION : AWS A/SFA 5.29 EN ISO 18276-A

E91T1-D1C/M T 55 4 MnMo R C/M 2

APPROVALS : RDSO Class III

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

WELDING POSITION :



DCEP

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
CO ₂	10-20	10-20
80Ar+20CO ₂	18-25	10-20

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

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	Mo	S	P
Specification	0.12 max	1.25-2.0	0.80 max	0.25-0.55	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 -40°C, J
Specification	As Welded	620-760	540 min	17 min	27 min

With mixed gas chemical composition and mechanical properties will be higher.

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