



FCAW C-Mn STEEL

AUTOMIG FC 71T-1C-J

A RUTILE TYPE FCAW WIRE FOR CARBON STEEL WELDING WITH SUB-ZERO IMPACT REQUIREMENT



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

T 42 4 R C 2

E71T-1C-J

ABS

KEY FEATURES :

- Rutile type gas shielded FCW wire
- Stable arc, Easy slag removal
- Smooth and porosity free weld
- Sound radiographic weld quality
- Excellent combination of T1 performance with very good sub-zero toughness down to -40°C
- All position capability

WELDING POSITION :



DCEP

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

TYPICAL APPLICATIONS :

- Welding of typical structural and carbon steel SA 36/36M, SA 285/285M Gr.A/B/C, SA 414/414M Gr.A/B/C
- Application in Ship building, Off-shore platform, Pressure vessels, Piping, Low temperature serving storage tanks, Harbor equipment

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.12 max	1.75 max	0.90 max	0.20 max	0.50 max	0.30 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 -40°C, J
Specification	As Welded	490 min	400 min	22 min	27 min

PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	20 – 30	130 - 300	15
1.6	24 – 32	200 - 380	15