



FCAW C-Mn STEEL
AUTOMIG FC 71T-5

A BASIC TYPE FCW WIRE FOR 500 MPa TENSILE STRENGTH STEEL



CLASSIFICATION : EN ISO 17632-A

AWS A/SFA 5.20

T 42 3 B C/M 2 H5

E71T-5C/M H4

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

KEY FEATURES :

- Basic type gas shielded FCW wire
- Stable arc, Easy slag removal
- Smooth and porosity free weld
- Crack resistant and tough welds especially when welding steels with high carbon content
- Very low level of diffusible H₂ content
- Suitable for high quality single and multi pass welding of thicker sections
- Superb mechanical properties
- All position capability
- Sound radiographic weld quality

WELDING POSITION :



DCEP

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

TYPICAL APPLICATIONS :

- Welding of structural and boiler quality steels with minimum UTS up to 510 Mpa
- Welding of heavy sections in Pressure vessels, Construction equipment, Off-shore structures, Bridges
- Suitable for IS 226, IS 2002, IS 2062, DIN 17115 HIV
- SA 285 Gr.C, SA 414 Gr.C/D/E
- SA 515 Gr.60/65, SA 516 Gr.60/65

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	0.05	1.0	0.3	0.01	0.01
Specification	0.08 max	1.75 max	0.25-0.60	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 -30°C, J
Typical	As Welded	575	500	26	50
Specification		500 min	420 min	22 min	47 avg

Diffusible H₂ Content: <4 ml/100 gm

Chemistry and mechanical properties tested with 100% CO₂ shielding gas

PARAMETERS - PACKING DATA :

Ø, mm	Voltage, V	Amperage, A	Kg/Spool
1.2	20 – 30	130 - 300	15
1.6	24 – 32	180 - 380	15

Use 1-2 volts lower when using mix shielding gas.