



FCAW LOW ALLOY STEEL (Low Temperature)
AUTOMIG FC 90T5-K2

LOW ALLOY STEEL FCAW WIRE WITH HIGH STRENGTH AND IMPACT PROPERTIES



CLASSIFICATION : AWS A/SFA 5.29 **APPROVALS :**

E90T5-K2C H4 -

KEY FEATURES :

- Basic type gas shielded FCW wire
- Stable and smooth arc
- Low fumes, Minimal spatters
- Easy slag removal
- Excellent low temperature toughness down to -50°C
- Suitable for high strength application
- Radiographic quality weld

WELDING POSITION :



DCEP

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

TYPICAL APPLICATIONS :

- Welding high strength, fine grained structural steels like N-A-XTRA 55, N-A-XTRA 60, LA60, Sailma 450/450HI
- High strength application of 550-760 MPa minimum yield strength steels
- Suitable for joining HY 80, HY 100, ASTM A710, A514 steels and similar high strength materials
- Offshore structures and structural applications

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt% :

| | C | Mn | Si | Ni | Cr | Mo | V | S | P |
|---------------|----------|-----------|----------|---------|----------|----------|----------|-----------|-----------|
| Specification | 0.15 max | 0.50-1.75 | 0.80 max | 1.0-2.0 | 0.15 max | 0.35 max | 0.05 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 -50°C, J |
|---------------|-----------|----------|------------------------|--------|------------------------|
| Specification | As Welded | 620-760 | 540 min | 17 min | 27 min |

Diffusible H₂ Content: <4 ml/100 gm

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 |