



AUTOMIG FC 71T-1

FCAW C-Mn STEEL

AWS A/SFA 5.20 **E71T-1C**

CLASSIFICATION:

EN ISO 17632-A
T 42 2 P C1 2

KEY FEATURES:

- Rutile type gas shielded FCW wire
- Low fumes, Minimal spatters
- Easy slag removal, smooth weld bead
- High deposition rate
- Suitable for high quality single and multi pass welds
- All position capability
- Radiographic quality weld

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

TYPICAL APPLICATIONS:

- Welding of C-Mn steel with tensile strength up to 500 MPa
- Bridges, Shipbuilding, Towers, Cranes
- Chemical plant machinery, Hulls
- Storage tanks, Structural steel
- Construction equipment, Farm machinery, Rolling stocks
- General carbon steel fabrication

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si
0.06	1.4	0.4

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C, J
Typical	As Welded	600	490	25	35

Hardness, 3 Layer: 200 BHN max

PARAMETERS - PACKING DATA:

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

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