



# AUTOMIG FC 101T1-K3

AWS A/SFA 5.29 E101T1-K3C

FCAW LOW ALLOY STEEL (High Strength)

### CLASSIFICATION:

EN ISO 18276-B  
T 693T1-1CA-N3M2

### KEY FEATURES:

- Rutile type gas shielded FCW wire
- Stable arc, Easy slag removal
- Low fumes, Minimal spatters
- Smooth and porosity free weld
- Optimal alloy control
- High strength and low temperature toughness combination
- Suitable for all position
- Radiographic quality weld

### APPROVALS: CE

### TYPICAL APPLICATIONS:

- Welding of higher strength steel pipes and plates
- Welding of SAILMA 450/450HI steel used in CONCOR wagons is a typical application for this wire


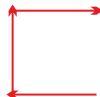
### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni	Mo
0.08	1.8	0.5	2.3	0.4

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -20°C, J
Specification	As Welded	690-830	610 min	16 min	27 min

### PARAMETERS - PACKING DATA:

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

Shielding Gas	Gas Flow Rate, LPM
CO <sub>2</sub>	15-20