



AUTOMIG FC 110T5-K4

AWS A/SFA 5.29 E110T5-K4C-H4

FCAW LOW ALLOY STEEL (High Strength)

CLASSIFICATION:

EN ISO 18276-A

T 69 5 Mn2NiCrMo B C1 3-H5

KEY FEATURES:

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

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of high strength, quenched and tempered fine grained steels like N-A-XTRA 65 & 70, USST1, T1B, WELTEN 70C
- Welding of SA533/533M Gr. B/C/D Class 2 & 3, SA543/543M Gr.B/C Class 1 & 2, SA225/225M Gr.C/D, SA738/738M Gr.A/B/C



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni	Cr	Mo
0.08	1.6	0.4	2.1	0.3	0.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -50°C, J
Typical	As Welded	810	730	18	50

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	

Diffusible H2 Content: <4 ml/100 gm

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