



AUTOMIG FC 71T-5

AWS A/SFA 5.20 **E71T-5C/M H4**

FCAW C-Mn STEEL

CLASSIFICATION:

EN ISO 17632-A
T 42 3 B C/M 2 H5

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
- Sound radiographic weld quality

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

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

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si
0.06	1.3	0.4

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	70

Diffusible H2 Content: <4 ml/100 gm

PARAMETERS - PACKING DATA:

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

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

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20
80Ar+20CO ₂	18-25