



AUTOMIG FC 90T5-K2

AWS A/SFA 5.29 E90T5-K2C/M-H4

FCAW LOW ALLOY STEEL (Low Temperature)

CLASSIFICATION:

EN ISO 17632-A

T 50 5 1.5Ni B C1/M21 3 H5

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

APPROVALS:CE

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

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


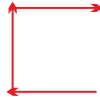
C	Mn	Si	Ni
0.08	1.3	0.45	1.4

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	660	590	22	50

Diffusible H2 Content: <4 ml/100 gm

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