

# AUTOMIG FC 71T-1 (MOD)\*

## Classification

AWSA/SFA 5.20 : E 71T - G

AWS A/SFA 5.20M : E 491T- G

## Flux Type

Rutile-Neutral

## Characteristics

A rutile type folded flux-cored wire with fast freezing slag and excellent welding performance for all position welding. Minimal spatter, easy slag removal, smooth and finely rippled weld bead without the undercuts. Performance is superior to solid wire in terms of current carrying capacity, bead appearance etc. X-ray quality sound and tough weld deposit with improved impact strength down to -46° C.

## Typical Applications

Welding structural steel, carbon manganese steels with specified tensile strength up to 500 N/mm<sup>2</sup> for fabrication of ships, machinery parts, steel frames, structures, bridges, towers, chemical plant, rolling stocks, vehicles, cranes, etc. Suitable for joining steels conforming to the specification: SA-36/SA-36M (P. No. 1) A, B, C grades of SA-285/SA-285M (P. No. 1) A, B, C, D grades of SA-414/SA-414M (P. No. 1)

Shielding Gas: CO<sub>2</sub>

10-15 litres/min

Current Condition: DC (+)

## Weld Metal Chemistry, wt %

C	Mn	Si	S	P	Ni
0.10 max	0.90-1.40	0.55 max	0.025 max	0.025 max	0.80

Diffusible H<sub>2</sub> content <5 ml/100gms of weld metal

## All Weld Metal Mechanical Properties:

Condition	UTS MPa	YS MPa	Elongation % (L=4×d)	CVN Impact, J -46°C
AW	490 min	390 min	22 min	27 min

AW: As Welded

Chemical & mechanical properties given above are with A 5.32 SG-C gas (100% CO<sub>2</sub>)

The chemistry and mechanical properties of the weld will vary with the type of shielding gas.

Welding Positions

F, H, V-up and OH

## Packing Data

Dia., mm	1.2	1.6
Plastic Spools, net wt Kg	15	15

\* Formerly known as - AUTOMIG FC 120T



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