

AUTOMIG FC 71T-1*

Classification

AWS A/SFA 5.20 : E 71T-1C
 AWS A/SFA 5.20M : E 491T-1C

Approvals :

LRS	3S, 3YS,H5,NA	ABS	3YSAH5,E71T1H4
IBR	E 71-T1	BV	3YMHHH
BHEL	E 71-T1	DNV	III YMS (H5)
RDSO (Class I)		IRS	3YSHHH
GL	3YSH5S		

Flux Type

Rutile-Neutral

Characteristics

A rutile type folded flux-cored wire suitable for all position welding. Welding can be carried out at relatively higher welding current density, higher deposition rates are obtainable than the solid wire electrodes. The electric arc is smooth & stable with least spatters and easy slag detachability. The weld bead is characterized by its smooth & excellent appearance.

Typical Applications

Welding of structural & carbon manganese steels with specified tensile strength up to 500 N/mm² for fabrication of machinery parts, steel frames, steel structures, bridges, towers, cranes, ships, vehicles, chemical plant machinery, rolling stocks, etc. Suitable for joining steels conforming to ASTM 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: CO₂

10-15 litres/min

Current Condition: DC (+)

Weld Metal Chemistry, wt %

C	Mn	Si	S	P
0.10 max	0.90-1.75	0.55 max	0.025 max	0.025 max

Diffusible H₂ content <5 ml/100gms of weld metal

All Weld Metal Mechanical Properties:

Condition	UTS MPa	YS MPa	Elongation % (L=4×d)	CVN Impact, J -20°C
AW	490 min	390 min	22 min	50

AW: As Welded

Chemical & mechanical properties given above are with A 5.32 SG-C gas (100% CO₂)

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

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 120



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