

AUTOMIG FC 71T-5*

Classification

AWSA/SFA 5.20 : E 71T-5C H4 /E 71T-5M H4

Flux Type : Basic

Characteristics

A basic type folded flux-cored wire producing weld metal with sound radiographic quality and superb mechanical properties. The wire deposits are very crack resistant and tough welded joints, especially when welding steels with high carbon content. Stable arc, easy deslagging, pore-free welds.

Typical Applications

Welding of structural and boiler quality steels with minimum UTS upto 510 Mpa, including 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, etc.

Approvals :

ABS Gr. III, YSAH5, E71T5H4
BV SA3YMHHH
DNV Gr. III YMS H5
IRS 3YSHHH
LRS DXVuo, BF, 3S, 3YS, H5, NA

Shielding Gas: CO₂

10-15 litres/min

Current Condition: DC (+)

Weld Metal Chemistry, wt %

| C | Mn | Si | S | P |
|----------|----------|---------------|-----------|-----------|
| 0.08 max | 1.75 max | 0.25-0.60 max | 0.025 max | 0.025 max |

Diffusible H₂ content < 4 ml/100gms of weld metal

All Weld Metal Mechanical Properties:

| Condition | UTS MPa | YS MPa | Elongation % (L=4×d) | CVN Impact, J -30°C |
|-----------|------------|-----------|-------------------------|------------------------|
| AW | 490 min | 390 min | 22 min | 50 min |

AW: As Welded

Chemical & mechanical properties given above are with A5.32 SG-C gas (100% CO₂)

The chemistry and mechanical properties of the weld 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 310



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