

AUTOMIG FC 90T5-K2*

Classification
AWS A/SFA 5.29
E90T5-K2C

Flux Type
Basic

Characteristics:

It is a low alloy basic type folded flux-cored wire with CO₂ gas shielding. Low spatter, easy slag removal, uniform weld bead giving radiographic sound weld are the special features of this wire.

Typical Applications

For welding high tensile strength, fine grained structural steels like N-A-XTRA 55, N-A-XTRA 60, WB-35, BHW-33, BHW-33, BHW-38, HOAG welmonil, LA 60, Sailma-450, Sailma-450HI, Tiscral etc. Suitable for joining steels conforming to the specifications: ● SA-455/SA-455M (P. No. -1), ● Gr-60, Gr-65 steels of SA-515/SA-515M (P. No. -1), ● Gr-55, Gr-60, Gr-65 steels of SA-516/SA516M (P. No. -1), ● Class-1 of A, B, C, D grades of SA-533/SA-533M (P. No. -3).

Shielding Gas: CO₂

10-15 litres/min

Current Condition: DC (+)

Weld Metal Chemistry, wt %

C	Mn	Si	S	P	Mo	Cr	Ni
0.15 max	0.5 -1.75	0.80 max	0.030 max	0.030 max	0.35 max	0.15 max	1.0-2.0

Diffusible H₂ content: <5 ml / 100gm of weld metal

All Weld Metal Mechanical Properties:

Condition	UTS MPa	YS MPa	Elongation % (L=4×d)	CVN Impact, J -50°C
AW: As Welded	620 -760	540 min	17 min	27 min

Chemical & mechanical properties given above are with A 5.32 SG-C gas (100% CO₂)
The chemistry and mechanical properties of the weld will vary with the type of shielding gas.

Welding Positions

Flat & horizontal

Packing Data

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

* Formerly known as - AUTOMIG FC 410



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