



: 7 K ' & ' + A

Classification

AWS A5.28 : ~E91T1-B3M H4

EN 17634-A: T CrMo2 M M 1 H5

EN 17634-B: T 62 T15 1M 2C1M H5

Description & Applications

FCW 237M is metal cored wire without slag for Ar-Co2 Mix .Good arc restricking even with cold Wire tip,suitable for robbot applications.Wire shows excellent gap bridging for root welding.21/4Cr1Mo steels. Wire usuly used in construction of containers,boilers,machines & pipe work,Steam boilers,steam turbines.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Mo	P	S
0.07	0.30	1.10	2.20	1.00	0.010	0.010

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
650	750	18	-20°C 65
After PWHT 705°C/1h			

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Pulsed arc (A)	(V)	
FCAW = +	1.2 1.6	220-250	24-28	M21

Ind.10



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.