



FCW 50-B

Seamless basic cored wire

Classification

AWS A5.36 : E70T5-M21A4-CS1-H4

ISO 17632-A : T 42 4 B M 1 H5 / T 42 4 B C 1 H5

Description & Applications

Basic flux cored wire for gas shielded (Ar + CO₂ or 100% CO₂) arc welding Carbon, Carbon-Manganese and similar steels. Can be used in all positions with DC- polarity for upward vertical. Excellent mechanical properties at low temperature up to -60°C.

Main applications: General steel constructions, pressure vessels, shipyards...

Base materials

Construction steels	EN 10025	S185 to S355
Pressure vessels	EN 10028-2	P235GH to P355GH
Fine grain steels	EN 10113	S275 to S420
Pipe steels	EN 10208	L210 to L415
	API5LX	X42, X46, X52, X60
Ship steels	A, B, C, D, and A (H) 32 to D (H) 36	

Typical Chemical Composition (%)

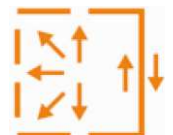
Gas	C	Si	Mn	Cr	Ni	Mo	Cu	V	P	S	Fe
M21	0.07	0.60	1.50	0.03	0.02	0.01	0.07	0.005	0.015	0.010	Rem.
C1	0.06	0.50	1.30	0.03	0.02	0.01	0.07	0.005	0.015	0.010	Rem.

Typical All Weld Metal Mechanical Properties

Condition	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
As Welded (M21: Ar-CO ₂)	420	550	22	-40°C	100
				-60°C	90
As Welded (C1: CO ₂)	420	530	22	-40°C	90
				-60°C	80

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +/-	1.0	80 - 250	15 - 25	10 - 25	ISO 14175 : C1 (CO ₂) 15-20 l/min
	1.2	100 - 300	16 - 36		
	1.6	130 - 400	19 - 38		



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