



FCW 51-M HP

Universal Metal Cored for all positions

Classification

AWS A5.36 : E70T15-M21A8-CS1-H4 ISO 17632-A : T 46 6 M M 1 H5
 AWS A5.36 : E70T15-C1A6-CS1-H4 ISO 17632-A : T 42 5 M C 1 H5

Description & Applications

Metal cored wire for welding in all positions of Carbon, Carbon – Manganese and similar types of steels, including fine grain steels with Ar-CO₂ or pure CO₂ shielding gas. High yield, good weldability, excellent bead appearance, very low spatters losses. Excellent mechanical properties at low temperature (-60°C) in as welded conditions or after post weld heat treatment. Especially used for automated-robotized applications and for root pass welding on pipe or plate.

Main applications: General steel constructions, shipyards...

Typical Chemical Composition (%)

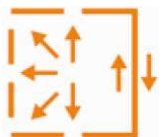
Gas	C	Si	Mn	Ni	Cr	Cu	Mo	V	S	P	Fe
M21	0.06	0.80	1.60	0.02	0.03	0.07	0.01	0.005	0.01	0.01	Rem.
C1	0.05	0.60	1.50	0.02	0.03	0.07	0.01	0.005	0.01	0.01	Rem.

Typical All Weld Metal Mechanical Properties

Condition	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
AW (M21: Ar-CO ₂)	500	600	29	-40°C	90
				-60°C	60
AW (C1: CO ₂)	460	560	30	-40°C	80
				-50°C	60
PWHT 620°C/2h	420	510	24	-40°C	90

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.0	150 - 380	16 - 36	10 - 25	ISO 14175 : M21 (Ar/CO ₂) C1 (CO ₂)
	1.2				
	1.4				
	1.6				



FT En-CA10-160211

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