



FCW 51-M

Universal Metal Cored

Classification

AWS A5.18 : E70C-6M H4

ISO 17632-A : T 42 3 M M 1 H5

Description & Applications

Metal cored wire for gas shielded arc welding of low alloys in flat position with Ar-CO₂ mix.

Main applications: General steel constructions, foundries, shipyards...

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	V	P	S	Fe
0.04	0.60	1.25	0.04	0.02	0.01	0.02	0.01	0.015	0.010	Rem.

Typical All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
465	530	30	-30°C 60

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	150 - 310	16 - 35	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12-15 l/min



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