



# FCW 51-R

*Universal rutile flux cored*

## Classification

AWS A5.18 : E71T-1M

ISO 17632-A

T 46 2 P M 1 H10

## Description & Applications

Rutile flux cored wire for gas shielded arc welding low alloys in all positions for Ar-CO<sub>2</sub> mix

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

## Typical Chemical Composition ( % )

C	Si	Mn	S	P	Cr	Ni	Mo	V	Cu	Fe
0.05	0.40	1.10	0.01	0.015	0.06	0.01	0.01	0.02	0.01	Rem.

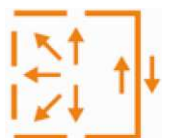
## Typical All Weld Metal Mechanical Properties

R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
560	590	28	-20 70

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	120 - 350	15 - 25	12 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 20 - 25 l/min
	1.6	180 - 450	18 - 30		

FT En-CA01-160211



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