



# FCW 56-R

Seamless Rutile Cored wire

## Classification

AWS A5.20: E71T-1(M) H4  
 AWS A5.36: E71T1-M21A4-CS1 / E71T1-C1A2-CS1-H4

ISO 17632-A: T 46 4 P M 1 H5 / T 42 2 P C 1 H5

## Description & Applications

Copper coated rutile flux cored wire for gas shielded arc welding low alloys in all positions for Ar-CO<sub>2</sub> mix or CO<sub>2</sub> pure gas. The fast freezing and easy remove slag is designed to weld in all positions.

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

## Typical Chemical Composition ( % )

C	Si	Mn	S	P	Cr	Ni	Mo	V	Cu	Nb	Al	Ti	B	Fe
0.065	0.50	1.60	0.01	0.015	0.04	0.02	0.005	0.01	0.10	0.01	0.005	0.05	0.005	Rem.

## Typical All Weld Metal Mechanical Properties

Gas	R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )	
M21	510	580	26	-40°C	75
C1	> 420	500 - 640	> 22	-20°C	> 60

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.0	160 - 270	21 - 34	10 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) C1 ( CO <sub>2</sub> ) 14 - 20 l/min
	1.2	190 - 320	22 - 35		



FT En-CA03-160211

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