



FCW 76-M

*Metal cored wire
For high strength steels*

Classification

AWS A5.28 : E100C-K3 H4

ISO 18276-A

T 62 6 Mn1NiMo M M 1 H5

Description & Applications

Metal cored wire, alloyed with Nickel (1%) for welding high strength steel with similar chemical composition with shielding gas (Ar + CO₂). Excellent weldability in all positions in single or multi pass. Good mechanical properties at low temperature up to -60°C.

Main applications: Off-shore, pipelines, vessels, general fabrication...

Base materials

High strength steels

ASTM	: A517; A537
EN 10028	: P500GH – P620GH; P500T1, T2; P620NL2; L620MB S500 – S620QL1
API	: Up to X90

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	V	P	S	Fe
0.05	0.50	1.5	0.01	0.90	0.50	0.05	0.01	0.015	0.015	Rem.

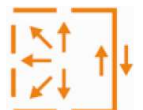
Typical All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
>620	690-890	20	-40°C	60
			-60°C	47

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	100 - 300	19 - 27	10 - 20	ISO 14175 : M21 (Ar/CO ₂) 15 l/min
	1.6	200 - 400	15 - 35	10 - 20	

FT En-CF16-160729



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