



FCW 77-B

*Basic flux cored wire
For high strength steels*

Classification

AWS A5.36 : E110T5-M21A8-K4-H4

ISO 18276-A

T 69 6 Mn2NiCrMo B M 3 H5

Description & Applications

Basic flux cored wire, Nickel, Chromium and Molybdenum alloyed for welding low alloyed and high strength steels with Ar + CO₂ shielding gas. Exceptional mechanical properties at low temperatures (-60°C). Good weldability in flat position, excellent bead appearance, and low spatters losses.

Main applications: Cranes, vessel and apparatus construction

Base material:

High strength steels

EN- Designation	S620Q, S620QL, S690Q, S690QL, S620QL1-S690QL1, alform plate 620 M, 700 M, aldur 620 Q, 620 QL, 620 QL1, aldur 700 Q, 700 QL, 700 QL1
ASTM	A 514 Gr. F, H, Q ; A 709 Gr. 100 Type B, E, F, H, Q ; A 709 Gr. HPS 100W

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	V	P	S	Fe
0.06	0.40	1.40	0.40	2.20	0.40	0.08	0.005	0.015	0.015	Rem.

Typical All Weld Metal Mechanical Properties

R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
740	800	20	-60°C 80

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 ₂) 12-15 l/min
	1.2	190 - 320	22 - 35		
	1.4	200 - 350	23 - 36		
	1.6	210 - 380	23 - 37		

FT En-CF12-160211



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