



# FCW 77-M

High strength metal cored wire

## Classification

AWS A5.28 : E110C-K4 H4      ISO 18276-A      T 69 4 Mn2NiCrMo M M 1 H5

## Description & Applications

Metal cored tubular wire for high strength steel for semi- and automatic gas shielded arc welding.

**Main applications:** Cranes, vessel and apparatus construction

**Base material:**

**High strength steels**

EN- Designation	S500QL – S690QL Weldox 700, HY80, HY100
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## Typical Chemical Composition ( % )

C	Mn	Si	P	S	Ni	Cr	Mo	V	Cu	Fe
0.06	1.50	0.50	0.015	0.015	2.50	0.50	0.50	< 0.03	<0.35	Rem.

## Typical All Weld Metal Mechanical Properties

R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
760	820	17	-40°C      60

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Intensity(A)	Voltage (V)	Stick-out (mm)	
MIG = +	1.2	100 - 350	15 - 35	12-25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) 12-15 l/min
	1.6	120 - 400	15 - 35	15-25	

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