



# FCW OA

Flux cored wire OPEN-ARC

## Classification

AWS A5.20 : E71T-GS

ISO 17632-A : T 42 Z W N 1 H15

## Description & Applications

Flux cored wire to weld carbon steels for Open-Arc welding without shielding gas in all positions. Easy slag removal.

**Main applications:** Steel constructions, for shipbuilding, for railways, for maintenance works in mines, quarries, agriculture.

**Base materials:**

**Construction steels for general use :**

Designation-EN	S185 – S355	L210 – L360
	P235 – P355	
ASTM	A285 grade C	A414 grade C, D, E
	A442 grade 55, 60	A515 grade 55, 60

## Typical Chemical Composition ( % )

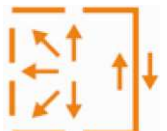
C	Si	Mn	Cr	Ni	Mo	Cu	V	Al	P	S	Fe
0.15	0.40	1.0	0.02	0.03	0.02	0.02	0.005	0.9	0.015	0.010	Rem.

## Typical All Weld Metal Mechanical Properties

R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )
470	570	24

## Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.0	90 - 240	15 - 28		-
	1.2	90 - 310	16 - 35		



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