



FCW 51-M HP

*High Performance
Universal Metal Cored wire
For all positions*

Classification

AWS A5.36 : E71T15-M21A8-CS1-H4 ISO 17632-A : T 46 6 M M21 1 H5
AWS A5.36 : E71T15-C1A6-CS1-H4 ISO 17632-A : T 42 5 M C1 1 H5

Description & Applications

Metal cored wire for welding in all positions of Carbon, Carbon – Manganese and similar types of steels, including fine grain steels with Ar-CO₂ or pure CO₂ shielding gas. High yield, good weldability, excellent bead appearance, very low spatters losses. Excellent mechanical properties at low temperature (-60°C) in as welded conditions or after post weld heat treatment. Especially used for automated-robotized applications and for root pass welding on pipe or plate.

Main applications: General steel constructions, shipyards...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	Nb	V	P	S
Min											
Max	0.12	0.90	1.75	0.20	0.50	0.2	0.3	0.05	0.08	0.030	0.030
Type gaz M21	0.06	0.80	1.60	0.03	0.02	0.01	0.07	0.01	0.005	0.01	0.01
Type gaz C1	0.05	0.60	1.50	0.03	0.02	0.01	0.07	0.01	0.005	0.01	0.01

Typical All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)	
Min	460	530	22	-60°C	47
Max		660			
Type gas M21	500	600	29	-40°C	90
				-60°C	60
Type gas C1	460	560	30	-40°C	80
				-50°C	60
TTAS 620°C/2h	420	510	24	-40°C	90

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.0 1.2 1.4 1.6	150 - 380	16 - 36	10 - 25	ISO 14175 : M21 (Ar/CO ₂) C1 (CO ₂)



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