



FCW 51-M

Universal Metal Cored

Classification

AWS A5.18 : E70C-6M H4

ISO 17632-A : T 42 3 M M21 1 H5

Description & Applications

Metal cored wire for gas shielded arc welding of low alloys in all positions with Ar-CO₂ mix. Mainly used in flat and horizontal positions.

Main applications: General steel constructions, foundries, 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	0.03	0.03
Type	0.04	0.60	1.25	0.04	0.02	0.01	0.02	0.01	0.01	0.015	0.010

Cr+Ni+Mo+V <0.50

Typical All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	420	500	22	-30°C 47
Max		640		
Type	465	530	30	-30°C 60

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	150 - 310	16 - 35	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12-15 l/min



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