



FCW 51-MF

Metal cored wire for unalloyed steels

Classification

AWS A5.18 : E70C-6M H4

ISO 17632-A : T 46 4 M M21 2 H5

Description & Applications

Metal cored wire without slag for welding unalloyed steels like C-Mn steels in all positions except in vertical down hand. Soft fusion and arc stable. Low projections. Suitable for manual or robotic applications.

Main applications: General steel constructions, foundries, shipyards...

Base materials

Construction steels	EN 10025	S185 to S355
Pressure vessels	EN 10028-2	P235GH to P355GH
Fine grain steels	EN 10113	S275 to S420
Pipe steels	EN 10208	L210 to L415
	API5LX	X42, X46, X52, X60
Ship steels	A, B, C, D, and A (H)	32 to D (H) 36

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	V	P	S
Min										
Max	0.12	0.90	1.75	0.20	0.50	0.30	0.50	0.08	0.03	0.03
Type	0.06	0.60	1.60	0.04	0.02	0.01	0.02	0.01	0.015	0.010

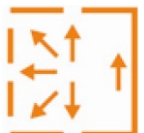
Typical All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	460	530	22	-40°C 47
Max		680		
Type	500	580	25	-20°C 100 -40°C 80

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.0	100 - 200	18 - 30	10 - 25	ISO 14175 : M21 (Ar/CO ₂) 12-20 l/min
	1.2	150 - 300	20 - 33		
	1.4	200 - 350	22 - 35		

FT En-CA14-220525



Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr