



## FCW 56-R

*Seamless Rutile Cored wire*

### Classification

AWS A5.36 : E71T1-M21A4-CS1-H4  
AWS A5.36 : E71T1-C1A2-CS1-H4

ISO 17632-A : T 46 4 P M21 1 H5  
ISO 17632-A : T 46 2 P C1 1 H5

### Description & Applications

Copper coated rutile flux cored wire for gas shielded arc welding low alloys in all positions for Ar-CO<sub>2</sub> mix or CO<sub>2</sub> pure gas. The fast freezing and easy remove slag is designed to weld in all positions.

**Main applications:** General steel constructions, pressure vessels, 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	0.065	0.50	1.60	0.04	0.02	0.005	0.10	0.01	0.01	0.015	0.010

### Typical All Weld Metal Mechanical Properties

		R <sub>e</sub> ( MPa )	R <sub>m</sub> ( MPa )	A <sub>5</sub> ( % )	KV ( J )
Min	gas	460	530	22	-40°C 47
Max	M21		660		-45°C 27
Type	gas M21	510	580	26	-40°C 75
					-45°C 65
Type	gas C1	>460	530-660	>22	-20°C >60

### Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.0 1.2	160 - 270 190 - 320	21 - 34 22 - 35	10 - 25	ISO 14175 : M21 (Ar/CO <sub>2</sub> ) C1 ( CO <sub>2</sub> ) 14 - 20 l/min



FT En-CA03-220324

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