



FCW 710M

*High Performance
Universal Metal Cored wire
For all positions*

Classification

AWS A5.18 : E70C-6M H4

ISO 17632-A : T 46 6 M M21 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 recovery, good weldability, excellent bead appearance, very low spatters losses, without slag. Excellent mechanical properties at low temperature up to -60°C. 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	0.05	0.70	1.50	0.02	0.03	0.01	0.12	0.01	0.010	0.015	0.010

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	490	570	30	-20°C 100 -60°C 80

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)



FT En-CAF2-240207

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