



FCW M75Cu

*Metal cored wire
Type CORTEN*

Classification

AWS A5.28 : E70C-G-H4

ISO 17632-A : T 46 2 Z M M21 1 H5

Description & Applications

Metal cored wire with Chromium, Nickel and Copper alloyed for welding COR-TEN type steels with Ar + CO₂ gas shielded. Good weldability, low spatter.

Main applications: Public works, steels construction, shipyard...

Base material:

Steels with improved resistance to atmospheric corrosion

EN- Designation	S235J0W, S235J2W, S355J2G1W
	COR-TEN A, COR-TEN B, Patinax 37...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	V	Nb	P	S
Min											
Max											
Type	0.05	0.50	1.1	0.50	0.40	0.02	0.40	0.005	0.01	0.015	0.015

Typical All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	460	530	20	-20°C
Max		680		47
Type	510	570	24	-20°C
				80

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.2	100 - 350	15 - 35	12 - 25	ISO 14175 : M21 (Ar/CO ₂) 12 - 15 l/min
	1.6	130 - 450	15 - 35	15 - 25	



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