



FCW OA

Flux cored wire OPEN-ARC

Classification

AWS A5.20 : E71T-GS

ISO 17632-A : T 42 Z W NO 1 H15

Description & Applications

Flux cored wire to weld carbon steels for Open-Arc welding without shielding gas in all positions. Easy slag removal. For single pass only.

Main applications: Steel constructions, for shipbuilding, for railways, for maintenance works in mines, quarries, agriculture.

Base materials:

Construction steels for general use :

Designation-EN	S185 – S355	L210 – L360
	P235 – P355	
ASTM	A285 grade C	A414 grade C, D, E
	A442 grade 55, 60	A515 grade 55, 60

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Cu	V	Nb	Al	P	S
Min												
Max			2.0	0.2	0.5	0.2	0.3	0.08	0.05	2.0		
Type	0.15	0.40	1.0	0.02	0.03	0.02	0.02	0.005	0.01	0.9	0.015	0.010

Typical All Weld Metal Mechanical Properties

	R _e (MPa)	R _m (MPa)	A ₅ (%)
Min	420	500	20
Max		640	
Type	470	570	24

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	
FCAW = +	1.0	90 - 240	15 - 28		-
	1.2	90 - 310	16 - 35		

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