

FCW 13

Rutile Flux Cored Welding Wire - Non Alloyed Steels

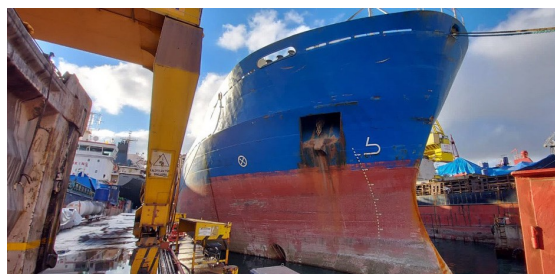
Standards	
AWS/ASME SFA - 5.20	E71T-1C H4
AWS/ASME SFA - 5.20	E71T-1M H4
AWS/ASME SFA - 5.20	E71T-9M-H4
EN ISO 17632 - A	T 46 3 P M21 1 H5
EN ISO 17632 - A	T 46 2 P C1 1 H5
TS EN ISO 17632 - A	T 46 3 P M21 1 H5
TS EN ISO 17632 - A	T 46 2 P C1 1 H5

Approvals & Certificates		
TL	DB	BV
ABS	CE	RINA
DNV	ClassNK	RMRS
CWB	LR	TUV

Materials	
EN	DIN
S255N - S420N	StE 255 - StE 420
S185 - S355J2	St 33- St 52.3
P235G1TH, P255G1TH	St 35.8 - St 45.8
P235GH, P265GH	H I, H II
P235TR2 - P355T2	St 37.4 - St 52.4
P295GH	17Mn4
L210 - L415NB	StE 210.7 - StE 415.7
L290MB - L415MB	StE 290.7 TM - StE 415.7 TM
GE 200, GE 240	GS 38, GS 45
	X42 - X60
	A, B, D, E
	X42 - X65

Properties and Applications

Rutile type flux cored wire, designed for welding in steel construction, piping, machine fabrication and shipbuilding by using M21-mix gas and CO₂ shielding gas. Owing to it's easily controllable weld pool and fast freezing slag particularly suited for welding in all position. Welding in all-position is easy with a wide parameter range, especially when using mixed gas. Good gap-bridging property, low spatter loss, easy slag removal even in narrow grooves. Finely ripped pore-free welds blending into base metal without undercut.



Typical Chemical Values of Weld Metal

Type of Analysis	Protection Gas	C	Si	Mn
Weld Deposit	C1	0.06	0.50	1.15
Weld Deposit	M21	0.06	0.60	1.40

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Yield Strength (N/mm ²)	Tensile Strength (N/mm ²)	Elongation A5 (%)	Charpy V-Notch Properties (J)	
As welded	C1	470	540	28	-20°C → 100	-30°C → 50
As welded	M21	530	620	25	-20°C → 100	-30°C → 80

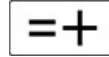
* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - M21 (Ar + %20 CO₂) .

Application Information

Welding Positions



Polarity:



Protection Gas:

M21 C1

Packaging Information

Product Code	Diameter (mm)	Pieces per Box (~)	Weight Of The Box (kg)	Boxes Per Package	Weight Of The Package	Packaging Type
31004DCAM2	1.00	5 kg	5.0	0	0.0	
31004DIAM2	1.00	15 kg	15.0	0	0.0	
31004ECAM2	1.20	5 kg	5.0	1	5.9	
31004EIAM2	1.20	15 kg	15.0	1	16.0	Plastic Spool (D300) VAC
31004GIAM2	1.60	15 kg	15.0	1	16.0	Plastic Spool (D300) VAC

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.