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Selectarc FCW 56-R DC+

STEEL

DESCRIPTION

Gas shielded rutile flux cored "seamless" wire with slag from a unique concept: **the shell is WELDED, DRAWN OUT AND COPPER CLADDED.** Used for welding low alloys steel and carbon-manganese steel with Ar-CO_2 mix or CO_2 pure gas. The fast freezing and easy remove slag is designed to weld in all positions.

CHARACTERISTICS

- Excellent all-position weldability
- Easy flux removal
- Exceptional moisture resistance
- Very low spatter
- Superior mechanical properties, even at low temperatures
- Better current carrying capability
- Improved arc stability and regular feed

CLASSIFICATION

AWS A5.20 :	E71T-1(M) H4
AWS A5.36 :	E71T1-M21A4-CS1-H4 / E71T1-C1A2-CS1-H4
ISO 17632-A :	T 46 4 P M 1 H5 / T 42 2 P C 1 H5

TYPICAL APPLICATIONS

General steel constructions, pressure vessels, shipyards. Steel: ASTM, A36, A285, A515, A516, A830

TYPICAL CHEMICAL COMPOSITION (%)

C	Si	Mn	Cr	Ni	Mo	Cu	V	Nb	Al	Ti	P	S	B	Fe
0.065	0.50	1.60	0.04	0.02	0.005	0.10	0.01	0.01	0.005	0.05	0.015	0.01	0.005	Base

MECHANICAL PROPERTIES

Gaz :	**Mix Ar/CO_2**	**CO_2**
Tensile Strength :	84 000 psi (580 MPa)	72 500-92 800 psi (500-640 MPa)
Yield Strength :	73 900 psi (510 MPa)	61 000 psi (420 MPa)
Elongation:	26%	22%

WELDING PARAMETERS

Shielding Gaz :	Mix Ar/CO_2 or CO_2	
Diameter :	1.2 mm (.045")	1.6mm (1/16")
Amperage :	190 - 320 A	210 – 380 A
Voltage :	22 - 35 V	23 – 37 V
Stick-out :	3/8" - 1"	3/8" - 1"
Gas flow (p.c.h) :	30 – 40	30 - 40

Packaging : 16 kg spool

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Specialized welding alloys and technology. For technical assistance or for ordering:

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