

FCW 13

Rutile Flux Cored Welding Wire - Non Alloyed Steels

Standards	
AWS/ASME SFA - 5.36	E71T1-M21A4-CS1
AWS/ASME SFA - 5.36	E71T1-C1A2-CS1
EN ISO 17632 - A	T 46 2 P C 1 H5
EN ISO 17632 - A	T 46 3 P M 1 H5
TS EN ISO 17632 - A	T 46 3 P M 1 H5
TS EN ISO 17632 - A	T 46 2 P C 1 H5

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.

Approvals & Certificates		
DB CWB	DNV-GL TUV	CWB
Materials		
Width	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	

Typical Chemical Values of Weld Metal			
Type of Analysis	C	Si	Mn
Weld Deposit	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
As welded	M21	530	620	25	-20°C → 100

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

Application Information

Welding Positions: PA, PB, PC, PD, PE, PF, PG

Polarity:

Protection Gas: M21 C1

Welding Parameters & Efficiency

Diameter (mm)
1.00
1.20
1.60

Packaging Information					
Product Code	Diameter (mm)	Quantity per Box	Box Gross Weight (Kg)	Boxes per Outer Box	Outer Box Gross Weight (Kg)
31004DIAM2	1.00	15 KG	0.00	0	0.00
31004EIAM2	1.20	15 KG	16.00	1	16.00
31004GIAM2	1.60	15 KG	16.00	1	16.00

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.