

Gas Shielded Type Flux Cored Wire (FCAW)

GMX 71

AWS A5.20M E491T-1C/ A5.20 E71T-1C
JIS Z 3313 T49J2T1-1CA- H10
ISO 17632-A-T 46 2 P C1 1

Product Features:

- Titania oxide type CO₂ Gas shield flux cored arc welding wire.
- Good bead appearance.
- Good crack resistance and mechanical properties.
- Good arc stability, less spatter loss and easy slag removal.

Applications:

- Suitable for welding of mild and 490 N/mm² high tensile strength steel structures on shipbuilding, buildings, bridges, machinery, heavy thickness steel castings and pressure vessels.

Typical chemical composition of all-weld metal (wt%)

C	Si	Mn	P	S	Fe
0.04	0.51	1.64	0.016	0.004	Bal.

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
546	597	28.0	83

Welding parameters

Diameter (mm)		1.2	1.4	1.6
Polarity		DC+	DC+	DC+
Ampere (A)	Flat, horizontal position	120~350	160~380	200~450
	Vertical upward position	120~250	150~260	180~280
	Vertical downward position	200~280	220~280	250~280
Shielding Gas		CO ₂	CO ₂	CO ₂

Note:

- Wire extension : 15~25mm (standard range).
- Shielding gas flow rate : 20~25 L/min.

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