

Gas Shielded Type Flux Cored Wire (FCAW)

GMX 71M

AWS A5.20M E491T-1M/ A5.20 E71T-1M
JIS Z 3313 T49J2T1-1MA-H10
ISO 17632-A-T 46 2 P M21 1

Product Features:

- Titania oxide type flux cored wire for welding with Ar+CO₂ mixed shielding gas.
- 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
0.05	0.48	1.23	0.018	0.006	Bal.

Typical mechanical properties of all-weld metal

Yield Strength N/mm ²	Tensile Strength N/mm ²	Elongation %	Impact value (-20°C) J
588	560	29.0	113

Welding parameters

Diameter (mm)		1.2	1.6
Polarity		DC+	DC+
Ampere (A)	Flat, horizontal position	120~350	200~450
	Vertical upward position	120~250	180~280
	Vertical downward position	200~280	250~280
Shielding Gas		80%Ar+20%CO ₂	80%Ar+20%CO ₂

Note:

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

Goodweld Corporation
No.99, Huangong Rd. Yongkang Tainan, Taiwan
Phone: 886-6-2331003 Fax: 886-6-2333213
All Right Reserved

GOOD
GOODWELD
www.goodweld.com.tw