

# Gas Shielded Type Flux Cored Wire (FCAW)

## GMX 71Ni

AWS A5.20M E491T-9CJ/ A5.20 E71T-9CJ  
JIS Z 3313 T49J4T1-1CA-H10  
ISO 17632-A-T 46 4 P C1 1

### Product Features:

- Titanic oxide type flux cored wire for welding of mild and 490N/mm<sup>2</sup> high tensile strength steel with CO<sub>2</sub> gas shielding gas.
- Good bead appearance.
- Few spatters and easy slag removal.
- Ni element contained for improving low temperature impact toughness and crack resistance.

### Applications:

- Suitable for welding of mild and 490 N/mm<sup>2</sup> 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     | Ni   | Fe   |
|------|------|------|-------|-------|------|------|
| 0.04 | 0.38 | 1.33 | 0.019 | 0.005 | 0.44 | Bal. |

Typical mechanical properties of all-weld metal

| Yield Strength<br>N/mm <sup>2</sup> | Tensile Strength<br>N/mm <sup>2</sup> | Elongation<br>% | Impact value<br>(-40°C) J |
|-------------------------------------|---------------------------------------|-----------------|---------------------------|
| 636                                 | 674                                   | 27              | 92                        |

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 |                            | CO <sub>2</sub> | CO <sub>2</sub> |

### 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  
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