

Gas Shielded Type Flux Cored Wire (FCAW)

GMX 719

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

Product Features:

- Titania oxide type Gas shield flux cored arc welding wire.
- Suitable for all positions welding.
- Unique slag system enables to use 100%CO₂ with wide operating parameters.
- Low spatter, smooth & stable arc, and excellent bead profile.

Applications:

- Suitable for structural steel, storage tank fabrications, earth moving and agriculture heavy equipment

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 (-40°C) J
546	597	28.0	83

Welding parameters

Diameter (mm)	1.2	1.6
Current	DC+	DC+
Amperage	150~300	180~400
Wire Extension	20~30mm	20~30mm
Shielding Gas	CO ₂	CO ₂

Note:

- Shielding gas flow rate : 20~25 L/min.

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