



AUTOMIG FC 180R

FCAW LOW ALLOY STEEL (Weathering Steel)

AWS A/SFA 5.29 **E81T1-W2C**

CLASSIFICATION:

EN ISO 17632-B
T 553T1-1C1A-NCC1

KEY FEATURES:

- Rutile type gas shielded FCW wire
- Stable and smooth arc
- Low fumes, Minimal spatters
- Easy slag removal, smooth weld bead
- Excellent corrosion resistance
- Matches coloring of ASTM weathering type structural steels
- Optimum combination of strength, ductility and notch toughness
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of typical weathering steel such as ASTM A242, A588, CORTEN A and B grade
- Joining medium high tensile steel type D40S used for ship-building

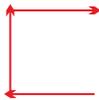
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Ni	Cr	Cu
0.7	1.1	0.4	0.5	0.5	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at -30°C, J
Typical	As Welded	590	520	21	35

PARAMETERS - PACKING DATA:

Ø, mm	Net Wt, Kg	
1.2	15	 DCEP All Positions, Except Vertical Down: 
1.6	15	

STORAGE / HANDLING :
Keep dry and follow handling instructions mentioned on the box

Shielding Gas	Gas Flow Rate, LPM
CO ₂	15-20