

AUTOMIG FC 110T5-K4*

Classification

AWSA/SFA 5.29 : E110T5-K4C

Flux Type

: Basic

Characteristics:

It is a basic type folded flux-cored wire with CO₂ gas shielding. Good arc stability and slag detachability are the special features. The weld has uniform bead appearance and radiographic soundness. The wire is suitable for joining high strength fine grained steels.

Typical Applications

For welding high strength, quenched and tempered fine grained steels like N-A-XTRA 65, N-A-XTRA 70, WB-35, USS T1, T1B, WELTEN 70C etc. Suitable for welding steels with specified tensile strength upto 690N/mm² and impact strength requirement down to -60°C. Suitable for joining steels conforming to specifications: ● C, D Grades of SA-225/SA-225M (P. No. -10A) ● Class 2, 3, of B, C, D grades of SA-533/SA-533M (P. No. -3), ● Class 1, 2 of B,C grades of SA-543/SA-543M (P. No. 11A & 11B) ● All thickness range of SA-612/SA-612M (P. No. 10C) ● A, B, C, grades of SA-738/SA-738M (P. No. -1).

Shielding Gas: CO₂

10-15 litres/min

Current Condition: DC (+)

All Weld Metal Chemistry, wt %

| C | Mn | Si | S | P | Mo | Cr | Ni |
|----------|------------|------|-----------|-----------|-----------|-----------|-----------|
| 0.15 max | 1.20 -2.25 | 0.80 | 0.030 max | 0.030 max | 0.20-0.65 | 0.20-0.60 | 1.75-2.60 |

Diffusible H₂ content ml/100gm: <5 ml / 100gm of weld metal

All Weld Metal Mechanical Properties:

| Condition | UTS | YS | % Elongation | CVN Impact, J |
|-----------|----------|---------|--------------|---------------|
| | MPa | MPa | (L=4×d) | At -51°C |
| AW | 760 -900 | 680 min | 15 min | 27 min |

AW: As Welded

Chemical & mechanical properties given above are with A5.32 SG-C gas (100% CO₂)

The chemistry and mechanical properties of the weld will vary with the type of shielding gas.

Welding Positions

Flat & Horizontal

Packing Specifications

| | | |
|---------------------------|-----|-----|
| Dia., mm | 1.2 | 1.6 |
| Plastic Spools, net wt Kg | 15 | 15 |

* Formerly known as - AUTOMIG FC 420



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