



NOUVARC FC-1

Flux Cored Arc Welding Wires

E71T1 AWS A.5.20 E71 T-1

Application :

For Mild steel and 490N/mm sq H.T.steels

Welding Process :

Flux cored Arc welding process Rutile Type FC W Good weld ability on all Position Fillet and Butt welding applications under Carbon dioxide shielding gas gives excellent Impact value. Less spatter and good easy slag detachability. Also recommended for semi and fully automatic welding applications.

Diameter of wire : 1.20mm and 1.60mm

Polarity : DC +

Chemical Composition of Weld Metal

	C	Mn	Si	S	P	Shielding Gas
AWS Specs	0.10% Max	1.00 to 1.60 %	0.50% Max	0.025% max	0.025% max	
Typical	0.07% Max	1.00 to 1.35 %	0.36% Max	0.013% Max	0.013% Max	100% Co2

Shielding Gas & Flow rate

Co2 or Argon+20%Co2 with flow rate of 10-15 liters/minute

Mechanical Properties of Weld Metal

	AWS Specs	Typical
UTS	480	560
YS	400	490
% Elongation	22 Min	30
IMPACT	-20 Deg C = 27J	40 J
Shielding Gas		100 % Co2

ISO 9001 Certified Company

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