



# NOUVARC FC-18-WR

## Flux Cored Arc Welding Wires

**AWS SFA : 5.29 E 81-T-1-W2**

### Application

Low Alloy Steel Gas Shielded flux cored wire Rutile based slag with easy detachability. It gives good and uniform weld beads with self detachability of slag. Less spatter.

Welding Process : Low Alloy steel for welding of CORTEN grade weather resistant steels.

### Typical Weld Metal Chemistry

C	Mn	Si	Ni
0.10% Max	0.90 to 1.30 %	0.50% Max	0.40 to 0.80%
Ch	Cr	S	P
0.45 to 0.70%	0.30 to 0.65%	0.025% max	0.025%max

### Polarity

DC wire positive

Size : 1.20mm and 1.60mm

### IRS Classification

IRS M- 46-2003(with Amendment no 1) E 81 T-1 W

Shielding Gas & Flow rate : Co<sub>2</sub> or Argon+20%Co<sub>2</sub>  
with flow rate of 10-15 liters/minute

### Typical Mechanical Properties of Weld Metal

Yield strength : 490N/mm Sq  
Ultimate tensile strength : 560 N/mmsq  
Elongation % : 20 Min  
Impact Value : -30 Deg Celsius 27J Min

ISO 9001 Certified Company

**Nouveaux Industries (P) Ltd.,**

2 Sowdambiga Nagar Tirupur Road  
KANGAYAM TN INDIA

Ph. +91 4257 220192

Fax +91 4257 222628

e-mail : sales@nouveaux.in

www.nouveaux.in