

GFC 719



CLASSIFICATION : AWS/SFA 5.20 : E 71T - 9C Also meets requirements of AWS/SFA 5.20 : E 71T - 12C

CHARACTERISTICS :

Tubular rutile flux-cored wire for single or multipass welding of carbon, carbon-manganese steels and similar grades of steels, including fine grain ones, with CO₂ shielding gas. The good weld ability in all positions, excellent bead appearance, less spatter, a fast freezing and easy to remove slag. Deposited weld metal gives excellent impact properties down to minus 30°C

TYPICAL WELD METAL ANALYSIS (%)

C	Mn	Si	S	P
0.04-0.10	0.90-1.50	0.30-0.65	0.030 max	0.030 max
Cr	Ni	MO	V	Cu
0.20 max	0.50 max	0.30 max	0.08 max	0.35 max

MECHANICAL PROPERTIES OF THE WELD METAL (RANGE)

Tensile Strength MPa	Yield Stress MPa	Elongation (%) (L=4D)	Charpy V-notch impact strength	
			Temp	Temp
510-650	440-540	22-30	- 30°C	50-100
			- 40°C	35-75

APPLICATIONS:

Ship building, railways wagons, general fabrication welding, Pipe welding, bridges, automobile parts, tanks, ASTM A516 grade 70 or equivalent Storage tanks, etc

SHIELDING GAS : CO₂

Flow Rate :14-20 l/min

RECOMMENDED CURRENT AND PACKING DATA :

SIZE (MM)	Amps DC (+)	Weight(KGS)
1.2	120 - 300	15
1.6	180 - 400	15