

# GFC 75



CLASSIFICATION : : AWS/SFA 5.20 : E71T-5

## CHARACTERISTICS :

GFC - 75 is a Basic Coated Flux Cored Wire with Excellent Characteristics and is suitable for steel with a Tensile Strength up to 600 N/mm<sup>2</sup> Deposited Weld Metal. Shows Superior Crack resistance, excellent at low temperature of - 20° to 30°

## TYPICAL APPLICATION :

Ship building machinery Structure, Bridge, Construction, Salvage plant facilities.

## 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

## MECHANICAL PROPERTIES OF THE WELD METAL (RANGE)

Ult.Tensile Strength MPa	Yield Stress Mpa	Elongation (%) (L=4D)	Charpy V-notch Impact Value	
			Temp	Joules
510-650	500-600	22-30	-30°C	50-100

## RECOMMENDED CURRENT AND PACKING DATA :

SIZE (MM)	AMPS DC( +)	VOLTAGE (V)	WEIGHT(KGS)
0.8	100-140	20-24	15

1.0	150-250	21-30	15
1.2	180-310	22-35	15
1.6	210-370	23-37	15