



F C - Mo

CODIFICATION : AWS : SFA 5.28 ER70S-A1

CHARACTERISTICS AND APPLICATIONS:

F C-Mo is a copper-coated solid wire for GTAW, available in bright finish. The wire gives stable arc, smooth welding performances and deposits radiographic quality welds. It is ideally suited for welding of low alloy ferritic steels of similar composition. The weld metal possesses good high temperature properties. Typical applications include the welding of Carbon Molybdenum steels such as, ASTM Grade F1 of SA-182 & SA-336, Grade A of SA-204, Grade T1/T1a/T1b of SA-209, Grade WC1 of SA-217, Grade A of SA-302, Grade P1 of SA-335, Class 1 of A grades of SA-533, etc.

TYPICAL CHEMICAL COMPOSITION OF SOLID WIRE:

Element	C	Mn	Si	S	P	Mo	Cu
%	0.065	1.20	0.45	0.010	0.012	0.55	0.10

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

(PWHT: 620°C FOR 1 HR)

UTS (MPa)	YS (MPa)	Elongation (L=4d) %
560	450	25.0

SHIELDING GAS : Argon

CURRENT CONDITION: DCEN

WELDING POSITION: H, F, VU, OH

APPROVAL: Adani Infra, BHEL, CIB-MP

PACKING:

STANDARD SIZE	Diameter 1.6 mm, 2.0 mm, 2.4 mm & 3.2 mm in cut lengths of 500 mm / 1000 mm each.
QUANTITY	5 kg wire put in an air-tight polythene bag and finally packed in a plastic container. Identification AWS code is punched on each wire.