



AMA FC 600R

AWS/ASME SFA 5.29
EN 758

E81T1-Ni1M-H4
T 46 6 1Ni P M 1 H5

properties:

AMA FC 600R is a low hydrogen rutile flux cored wire can be used in all welding positions. This wire has high arc stability and have good slag detachability. Its weld metal has good impact energy at -40°C and is suitable for welding fine-grained high-strength steels. This wire should be welded with mixed (M21) gas.

Typical All Weld Analysis:

Gas	C	Mn	Si	Ni
M21	0.04	1.10	0.25	0.9

Typical All Weld mechanical properties:

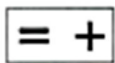
عملیات حرارتی	استحکام تسلیم (N/mm ²)	استحکام کششی (N/mm ²)	ازدیاد طول L ₀ = 5d %	انرژی ضربه (J) ISO - V -40 °C
As welded	≥ 460	550-690	≥ 22	≥ 80

Gas shield :EN ISO 14175: M21 (82% Ar+18% CO₂)

Flow rate :18-23 L/min

Operating Conditions:

Diameter (mm)	Stick-out (mm)	Voltage (V)	Current (A)
1.20	15-20	24-30	220-300
1.60	15-20	26-32	250-320



Packaging:

Diameter (mm)	Basket (KG)
1.20	15
1.60	15

Other weight & sizes are produced upon customers request.

The local welding wire spool is kept dry and away from storage on site. In addition, the welding wire spool is kept in a suitable plastic cover for storage after the end of each work shift.

Applications:

offshore industries, shipbuilding, bridge construction.