

ARCTEC® FCS 171

Conforms to: AWS A5.20 Class E71T-1/T-1M, T-9/T-9M
 Certified by CWB to CSA W48-01 E491T-9-H8 & E491T-9M-H8



a quality welding alloy

GENERAL CHARACTERISTICS:

ARCTEC® FCS 171 is an all position flux cored welding wire that can be used with either CO₂ or 75% Argon /25% CO₂ shielding gas. Produces x-ray quality weld deposits with a slag that is easily removed. A very smooth metal transfer facilitates easy deposition of vertical-up stringer beads. Fillet bead contour is flat to slightly convex with equal leg length. The spatter level is low and slag residue is minimal.

APPLICATIONS:

ARCTEC® FCS 171 is designed for all position single and multipass welding of low and medium carbon steels. Suitable for general repair and fabrication applications.

MECHANICAL PROPERTIES: (Typical)

Shielding Gas	Tensile Strength	Yield Strength	Elongation	ft/lb	Impact Strength	
					joules	Test Temperature
CO ₂	85000 psi 587 Mpa	78000 psi 538 Mpa	26%-2"	25	34	-20 ⁰ F / -29 ⁰ C
Argon/25% CO ₂	89500 psi 618 Mpa	85000 psi 587 Mpa	26%-2"	35	47	-20 ⁰ F / -29 ⁰ C

CHEMICAL COMPOSITION: (Undiluted)

Shielding Gas	C	Mn	Si	P	S
CO ₂	.025	1.40	.55	.010	.015
75% Argon/25% CO ₂	.035	1.60	.65	.010	.012

OPERATING PARAMETERS:

WELDING PROCESS: FCAW

POLARITY: DC Reverse

SHIELDING GAS AND FLOW RATE

CO₂ or 75% Argon/25% CO₂ at 30-40 CFH

Operating Range					
Diameter	Position	Stickout	Wire Feed Speed	Amps	Volts
.035"	Flat/Horizontal	3/8"(10mm)		90-180	20-30
.035"	Vertical up	3/8"(10mm)		150-250	16-23
.035"	Overhead	3/8"(10mm)		130-240	20-28
.045"	Flat/Horizontal	1/2"(12mm)	400"/min (1016cm/min)	150-290	23-30
.045"	Vertical up	1/2"(12mm)	190"/min(686cm/min)	150-210	22-27
.045"	Overhead	1/2"(12mm)	215"/min(851cm/min)	150-250	23-27
1/16"	Flat/ Horizontal	3/4"(19mm)	223"/min (566cm/min)	180-400	25-34
1/16"	Vertical up	3/4"(19mm)	138"/min (351cm/min)	180-250	21-27
1/16"	Overhead	3/4"(19mm)	160"/min (406cm/min)	180-310	22-27

STANDARD SIZE AND PACKAGING:

Size	12" spools	12" Coil
.035" .90mm	15 Kg	N/A
.045" 1.2mm	15 Kg	N/A
1/16" 1.6mm	15 Kg	27.2 Kg

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Subject to change without notice

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