

# GFC 550

## FLUX CORED WIRE OF BASIC TYPE

### IDENTIFICATION

GFC 550

### CLASSIFICATION

EN 758: T 42 4 M M 2 H5, DIN 8559: SG B1 CY 4254

### DESCRIPTION

Fluxcored wire has operating characteristics typical for basic type consumables. The weld metal exhibits excellent mechanical and is therefore outstanding for welding steels having a higher carbon content, easy slag removal, porosity free welds.

### WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Mo	S	P	Ni	Cr	Cu	V	Nb
0.03 - 0.10	2 max	0.9 max	0.2 max	0.02 max	0.02 max	0.5 max	0.2 max	0.3 max	0.08 max	0.05 max

### MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
550 - 640	420 min	20 min	-40°C	47

### MATERIALS

- Unalloyed structural steels such as St 33, St 37 -2 to St 52 - 3.
- Boiler plates such as HI, HII, 17 Mn 4, 19 Mn 5.
- Pipe steels such as St 37.0 to St 52.0
- Non-ageing steels such Ast A St 35 to St 52
- Steels to API-standard X42, X46
- Fine grain structural steels StE 255 to StE 355, WStE 255 ti WStE 355
- Shipbuilding steels A, B, D, E
- Cast steels GS-38, GS-60

**SHIELDING GAS :** M21

### PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1.2	15
1.6	15