

GFC 800B

IDENTIFICATION

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CLASSIFICATION

NF EN ISO 6847: T 69 4 Mn2NiCrMo B M 3 H5

DESCRIPTION

Fluxcored designed for welding high-strength fine grain structural steels. Low spatter loss, easy slag removal, smooth bead surface.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	Mo	S	P	Ni	Cr	Cu	V	Nb
0.06 - 0.09	1.30 - 1.70	0.25 - 0.55	0.30 - 0.60	0.02 Max	0.02 Max	2.0 - 2.5	0.30 - 0.60	0.15 max	0.03 max	0.05 max

MECHANICAL PROPERTIES (RANGE)

UTS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
780 - 940	470 min	17 min	-40°C	47

MATERIALS

Heat-treated the grain structural steels such as StE 620, StE 690.

SHIELDING GAS : M21

PACKING PARAMETERS

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