

# Tru-Core<sup>®</sup> CORED WELDING WIRES

## TYPICAL WELD METAL COMPOSITION (as required per AWS)

		C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
FC 70T	100% CO <sub>2</sub>	0.06	1.6	0.67	0.013	0.01	0.09	0.35	0.05	0.01	0.012
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.75 (max.)</b>	<b>0.90 (max.)</b>	<b>0.03 (max.)</b>	<b>0.03 (max.)</b>	<b>0.35 (max.)</b>	<b>0.50 (max.)</b>	<b>0.20 (max.)</b>	<b>0.30 (max.)</b>	<b>0.08 (max.)</b>
FC 71T	100% CO <sub>2</sub>	0.04	1.54	0.41	0.01	0.008	0.06	0.02	0.06	0.01	0.016
	75% Ar/25% CO <sub>2</sub>	0.05	1.41	0.45	0.009	0.01	0.06	0.02	0.03	0.002	0.017
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.75 (max.)</b>	<b>0.90 (max.)</b>	<b>0.03 (max.)</b>	<b>0.03 (max.)</b>	<b>0.35 (max.)</b>	<b>0.50 (max.)</b>	<b>0.20 (max.)</b>	<b>0.30 (max.)</b>	<b>0.08 (max.)</b>
FC 71T-12C	100% CO <sub>2</sub>	0.04	1.36	0.36	0.007	0.009	0.06	0.42	0.04	0.001	0.02
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.6 (max.)</b>	<b>0.9 (max.)</b>	<b>0.03 (max.)</b>	<b>0.03 (max.)</b>	<b>0.35 (max.)</b>	<b>0.5 (max.)</b>	<b>0.2 (max.)</b>	<b>0.3 (max.)</b>	<b>0.08 (max.)</b>
FC 71T-12C	75% Ar/25% CO <sub>2</sub>	0.05	1.35	0.32	0.011	0.007	0.06	0.39	0.05	0.01	0.019
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.6 (max.)</b>	<b>0.9 (max.)</b>	<b>0.03 (max.)</b>	<b>0.03 (max.)</b>	<b>0.35 (max.)</b>	<b>0.5 (max.)</b>	<b>0.2 (max.)</b>	<b>0.3 (max.)</b>	<b>0.08 (max.)</b>
FC 71T-AG	75% Ar/25% CO <sub>2</sub>	0.04	1.38	0.43	0.009	0.007	0.06	0.02	0.06	0.01	0.016
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.75 (max.)</b>	<b>0.90 (max.)</b>	<b>0.03 (max.)</b>	<b>0.03 (max.)</b>	<b>0.35 (max.)</b>	<b>0.50 (max.)</b>	<b>0.20 (max.)</b>	<b>0.30 (max.)</b>	<b>0.08 (max.)</b>
FC 71T-CG	100% CO <sub>2</sub>	0.05	1.38	0.35	0.01	0.007	0.06	0.48	0.05	0	0.014
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.75 (max.)</b>	<b>0.90 (max.)</b>	<b>0.03 (max.)</b>	<b>0.03 (max.)</b>	<b>0.35 (max.)</b>	<b>0.50 (max.)</b>	<b>0.20 (max.)</b>	<b>0.30 (max.)</b>	<b>0.08 (max.)</b>
FC 81T-Ni1	100% CO <sub>2</sub>	0.04	1.23	0.45	0.006	0.007		0.99	0.05	0.001	0.02
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.50 (max.)</b>	<b>0.80 (max.)</b>	<b>0.030 (max.)</b>	<b>0.030 (max.)</b>		<b>0.80 – 1.10</b>	<b>0.15 (max.)</b>	<b>0.35 (max.)</b>	<b>0.05 (max.)</b>
FC 81T-Ni1M	75% Ar/25% CO <sub>2</sub>	0.04	1.38	0.54	0.009	0.009		0.97	0.03	0	0.05
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.50 (max.)</b>	<b>0.80 (max.)</b>	<b>0.030 (max.)</b>	<b>0.030 (max.)</b>		<b>0.80 – 1.10</b>	<b>0.15 (max.)</b>	<b>0.35 (max.)</b>	<b>0.05 (max.)</b>
MC 70C	75% Ar/25% CO <sub>2</sub>	0.04	1.6	0.82	0.009	0.01	0.06	0.02	0.05	0.01	0
	90% Ar/10% CO <sub>2</sub>	0.04	1.61	0.85	0.006	0.009	0.05	0.02	0.04	0.001	<0.001
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.75 (max.)</b>	<b>0.90 (max.)</b>	<b>0.03 (max.)</b>	<b>0.03 (max.)</b>	<b>0.50 (max.)</b>	<b>0.50 (max.)</b>	<b>0.20 (max.)</b>	<b>0.30 (max.)</b>	<b>0.08 (max.)</b>
MC 80C-Ni1	95% Ar /5% O <sub>2</sub>	0.04	1.48	0.43	0.008	0.009	0.05	0.9		0.14	0
	75% Ar/25% CO <sub>2</sub>	0.04	1.41	0.4	0.008	0.009	0.05	0.94		0.14	0
	<b>AWS/ASME</b>	<b>0.12 (max.)</b>	<b>1.50 (max.)</b>	<b>0.90 (max.)</b>	<b>0.025 (max.)</b>	<b>0.030 (max.)</b>	<b>0.35 (max.)</b>	<b>0.80-1.10</b>		<b>0.30 (max.)</b>	<b>0.03 (max.)</b>
MC 110C-K4	95% Ar /5% O <sub>2</sub>	0.04	1.67	0.43	0.008	0.01	0.04	2.21	0.34	0.46	0
	<b>AWS/ASME</b>	<b>0.15 (max.)</b>	<b>0.75 – 2.25</b>	<b>0.80 (max.)</b>	<b>0.025 (max.)</b>	<b>0.025 (max.)</b>	<b>0.35 (max.)</b>	<b>0.50 – 2.50</b>	<b>0.15-0.65</b>	<b>0.25 – 0.65</b>	<b>0.03 (max.)</b>