



# Elgacore 791

FCAW - Flux cored arc welding  
Un-alloyed

Date: 2016-05-25  
Revision: 2

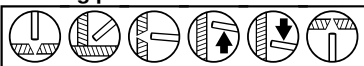
## Description:

Elgacore 791 is a flux-cored wire that is designed for general purpose fabrication, welding in all positions. It can be used with either 100% CO<sub>2</sub> or 75% Ar/25% CO<sub>2</sub> shielding gas, offering a spray type transfer of weld metal. Elgacore 791 provides good impact strength at low temperatures. It also has low spatter levels and the slag is easy to remove.

## Applications:

Mild and low alloy steels.

## Welding positions:



## Welding current:

DC+

## Deposition efficiency:

88%

## Shielding gas:

M21, 80% Ar+20% CO<sub>2</sub>, 17-24 l/min

C1, 100% CO<sub>2</sub>, 17-24 l/min

## Stick-out:

15-25 mm

## Hydrogen content / 100 g weld metal

≤ 5 ml

## Chemical composition, wt.%

	C	Si	Mn	P	S	Cr	Ni
Min							
Typical	0,022	0,82	1,6	0,014	0,01		
Max	0,12	0,90	1,75	0,03	0,03	0,20	0,50

	Mo	Cu	V	Nb
Min				
Typical				
Max	0,20	0,30	0,08	0,05

## Mechanical properties

	<u>Specified</u>	<u>Typical</u>
Yield strength, Re:	≥ 420 MPa	572 MPa
Tensile Strength, Rm:	500-640 MPa	618 MPa
Elongation, A5	≥ 22%	26%
Impact energy, CV:	-30°C • 47 J	-30°C • 177 J

## Classification:

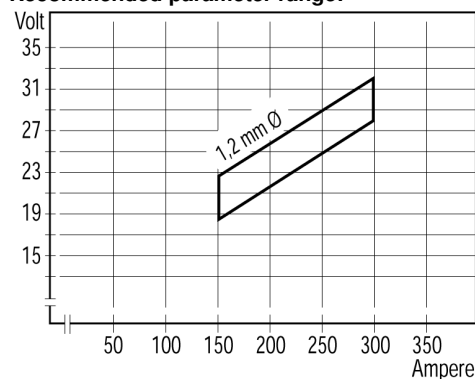
EN ISO 17632-A  
AWS A5.20

T 46 3 P/C M 2 H5  
E 71T-1C/M; E 71T-9C/M

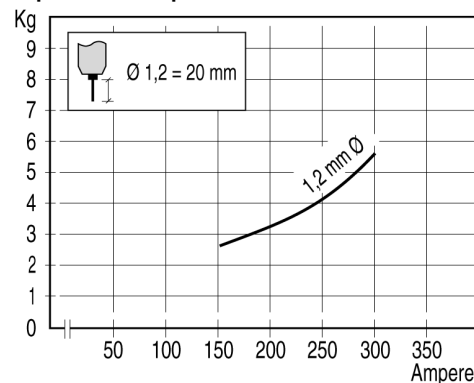
## Approvals:

CE  
ABS  
BV  
GL  
DNV  
LR

## Recommended parameter range:



## Deposition rate per hour:



## Product data:

Diam.mm	Product code	Spool weight
1,2	92601012	15 kg BS300
1,2	92602112	5 kg D200