

E-71T1

FLUX CORED ARC WELDING WIRE

AWS A5.20 E71T-1C

DESCRIPTION

E71T-1 is formulated to deposit x-ray quality welds in flat, vertical up, horizontal, or overhead positions. **E71T-1** is designed for welding low carbon and mild steel, structural and pressure vessel grades. **E71T-1** flux core ingredients produce a fast freezing slag that facilitates out of position welds. Bead contour is flat to slightly convex. Slag is easy to remove and low spatter provides easy post weld cleaning.

CORE TYPE:

Rutile

DEPOSITION EFFICIENCY

ca. 85%

WELDING CURRENT:

=(+)

HYDROGEN CONTENT:

< 10ml/100g of weld

APPROVALS:

GL 3YH10S
 LR 3YS
 BV SA3YH10
 ABS 4YSAH10
 KR 3YSG(C1)
 NKK KSW54G(C)

	Standards and steel grade		Gauge (mm)	Welding wire chemical composition (%)										
	GB	GB		C	Mn	Si	P	S	Cr	Ni	Mo	v	Cu	Ai
E71T-1	E501T-1	E718-1C	1.2-1.6	<=0.18	<=1.75	<=0.90	<=0.03	<=0.03	<=0.20	<=0.50	<=0.30	<=0.08	<=0.35	-

	Mechanical properties of deposited metal			
	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Akv impact (°C)
E71T-1	>=375	490-660	>=22	>=47(=20)

APPLICATION PARAMETERS

CDirect current electrode positive

Wire diameter	Approximate amperage	Approximate voltage	IPM feed rate
0.045"	110 - 280	19 - 28	175 - 290
1/16"	190 - 350	24 - 32	180 - 500

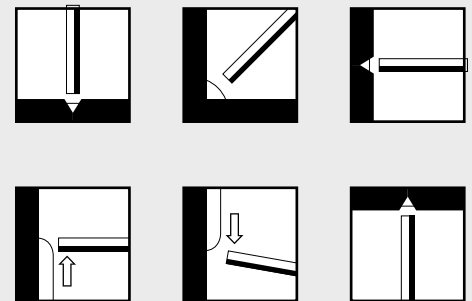
FEATURES

- Fast freezing slag for out-of-position welding.
- Premium arc performance and bead appearance shielding gas.

APPLICATIONS

- Shipbuilding.
- General fabrication.
- Barge and railcar fabrication.

WELDING POSITIONS



SHIELDING GAS

- 100% CO₂

DIAMETERS

- 0.045" (1.2mm)
- 1/16" (1.6mm)