



Product Data Sheet

Weld 71T

T 'Tubular cored electrode arc welding'

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GENERAL

A multi-purpose all positional rutile cored wire for use with CO2 shielding gas.

Shielding Gas: C1 (EN ISO 14175)

Alloy Type: C Mn

Polarity: DC+

Fill Type: Rutile

CLASSIFICATIONS Weld Metal

APPROVALS

SFA/AWS A5.20	E71T-1C H8	ABS	3YSA H10
SFA/AWS A5.36	E71T1-C1A0-CS2-H8	BV	S3Y H10
SFA/AWS A5.36	E71T1-C1A0-CS1 H8	CE	EN 13479
EN ISO 17632-A	T 46 2 P C1 1 H10	DNV-GL	III YMS(H10)
		LR	3YS H15

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C		0.09
Si	0.3	0.6
Mn	1.00	1.50
P		0.03
S		0.03
Cr		0.2
Ni		0.5
Mo		0.2
V		0.08
Cu		0.3

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded	
	Min	Max
Rp0.2 (MPa)	400	
Rm (MPa)	490	660
A4 (%)	22	
Charpy V at -20°C (J)	47	

ECONOMICS & CURRENT DATA

Dimension (mm)	Current (A)		W	η	H	Feed		U		
	Min	Max				Min	Max	Min	Max	
\emptyset			Nom	Nom	Min	Max	Min	Max	Min	Max
1.2	180	260	20	85	2.2	3.8	8.0	18.0	25	35
1.6	250	370	20	87	3.1	5.4	4.8	8.9	27	36

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)