

E71T-1C/M

AWS A5.20 E71T-1C/M

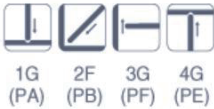
AWS A5.36 E71T1-C1/M21A2-CS1-H8

EN ISO 17632-B T42 0 P C 1

Description:

E71T-1C/M is a CO₂ & mixed gas dual use flux-cored wire used for all positional welding, can also be used for vertical down welding. Good operation properties like easy slag removal, stable arc, less smoke and spatter. Used to weld Carbon steels and 500MPa grade high strength steels.

Welding Position:



Diameters: 0,8mm, 1,0mm, 1,2mm, 1,4mm, 1,6mm

Typical Mechanical Properties:

Tensile strength(MPa):	565
Yield strength(MPa):	480
Elongation(%):	26
Impact values(≥47)/(-20 °C):	112

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	V
0,056	1,37	0,019	0,012	0,35	--	--	--	--

Welding Current:(DC+)

Diameter(mm)	1,2	1,4	1,6	
Current/A	--	140-300	150-360	180-400
Voltage/V	20-32	20-34	20-38	
Gas speed/(L/Min)	20-25	20-25	20-25	

Note:

1. Shield gas: 99.95% CO₂ or 80% Ar +20% CO₂;
2. Wire extension length: 15-25mm
3. Thermal input: 0.8-1.8KJ/mm, thick plate welding should be preheat.
4. Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
5. Stock in dry environment, please use up in short time once opened.