

E71T8-Ni1

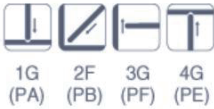
AWS A5.29 E71T8-Ni1

Description:

E71T8-Ni1 is designed for welding Grade X52-X60-X65 pipe and below for Onshore transmission pipelines requiring high impact toughness at low temperature, Good for variety of structural steel and general fabrication applications.

Single or multiple pass applications, no shielding gas required.

Welding Position:



Diameters: 1.2mm, 1.6mm

Typical Mechanical Properties:

Tensile strength(MPa):	532
Yield strength(MPa):	445
Elongation(%):	28
Impact values(≥ 27)/(-30°C):	120

Typical Chemical Compositon:

C	Mn	P	S	Si	Ni	Cr	Mo	Al
0.056	1.00	0.019	0.012	0.11	0.88	--	--	1.0

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

Note:

1. No shielding gas needed,
2. Rusty, oil stains, water and other impurity on the weld parts must be cleaned before welding.
3. Stock in dry environment, please use up in short time once opened.