

# E71T-1C/M

MILD-STEEL FLUX CORED WIRES, DUAL USE

## TYPICAL APPLICATIONS

1. Shipbuilding
2. General Fabrication
3. Structure Fabrication
4. Pressure Vessels

## CHARACTERISTICS

1. Fast freezing slag for out-of-position welding
2. Premium arc performance and bead appearance.
3. All positional welding capability
4. Comply with AWS D1.8 seismic lot waiver requirements



SIZE	AMPS
1.2mm	140-300A
1.6mm	180-400A

## CLASSIFICATION

AWS A5.20 E71T-1C/M  
 AWS A5.36 E71T1-C1/M21A2-CS1-H8  
 EN ISO17632-A-T 42 0 P C 1

## CHEMICAL COMPOSITIONS (Wt%), ALL WELD METAL, TYPICAL

C	Mn	Si	S	P
0.08	1.42	0.92	0.012	0.015

## WELDING POSITIONS (ISO/ASME)



## AVAILABLE SIZES (DIA.)

1.2mm/1.6mm

## PACKAGING DETAILS

15kg Spools, Vacuum pack ; 250kg Drums

## EQUIVALENT TO

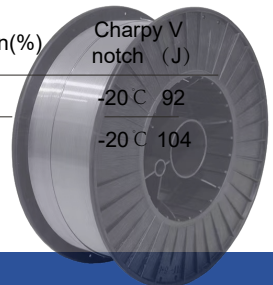
Lincoln Outershield 71 Elite    Esab OK E71T-1  
 Infra Frontiarc 711                Indura 71T-1  
 Bohler E71T-1C/1M

## CURRENT TYPE

DC+

## MECHANICAL PROPERTIES, ALL WELD METAL, TYPICAL

Condition	Shielding Gas	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation(%)	Charpy V notch (J)
AW	100% CO <sub>2</sub>	490	578	28	-20 C 92
	80% Ar+20% CO <sub>2</sub>	506	590	28	-20 C 104



### Note:

- ① Shielding gas: 100% CO<sub>2</sub> or 80% Ar+20% CO<sub>2</sub>; Gas speed 15-25L/Min.
- ② Wire extension length 15-25mm.