BOHLER Ti 71-T1C

Flux Cored Wire

Classification	
AWS A5.36	**EN ISO 17632-A**
E71T1-C1A0-CS1-H8	T42 2 P C 1 H10

Characteristics and typical fields of application

BOHLER Ti 71-T1C is a rutile flux cored wire with fast freezing slag. Excellent welding characteristics in all positions, using 100% CO_2 gas. Very good mechanical properties, easy slag removability, low spatter level, smooth and well shaped beads with X-ray-quality. Applicable in out-of-position welding, with higher productivity and less time for postweld cleaning.

Suitable for butt and fillet welding of hulls, storage tanks, mechanical and constructional steel structure and bridge.

Base Materials

S 235JR, S275JR, S355JR (st 33, st37-2, st44-2, st52-3), P235 GH, P265GH, API 5L X42 –X 60, AH 32, EH-36, A 40-F40, SA 516- Gr60, Gr65 …etc

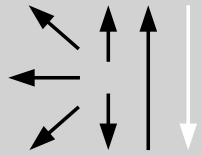
Typical analysis of all weld metal (wt.-%)

C	Si	Mn	P	S
Max. 0.12	Max. 0.90	Max. 1.75	Max. 0.03	Max. 0.03

Mechanical properties of all-weld metal

Heat treatment	Yield strength R_e N/mm^2	Tensile strength R_m N/mm^2	Elongation (L_0=5d_0)	Impact work ISO-V KV J
	MPa	MPa	%	- 20^{o}C
As Welded	$\geq$ 400	490 – 660	$\geq$ 22	$\geq$ 27

Operating data



Polarity
+ / DCEP

Shielding Gas : 100% CO_2
Interpass temperature: Max. 200^{o}C

Approvals

ABS, DNV-GL (0.045”, 1.2 and 1.6 mm), LR (1.2 and 1.6 mm), BKI (1.2 mm)

Size, Packaging and Electrical Operating Data

Size mm	Kg / Spool		Amperage (A)
	Type S200	Type S270/S300	
1.14 (0.045”)	5.0	15.0	120 – 280
1.2	5.0	15.0	120 – 280
1.6	5.0	15.0	230 – 450