



Weldarc E71 T-1 C

Unalloyed Flux Cored Wire

Classification				
AWS A5.36		AWS A5.20		EN ISO 17632 -A
E71T1-C1A2-CS1-H8		E71T-1C		T 42 2 PC1 H10
Characteristics and typical fields of application				
<p>WELDARC E71T - 1C is a rutile flux cored wire with fast freezing slag. Excellent welding characteristics in all positions. Very good mechanical properties, easy slag removability, low spatter level, smooth and well shaped beads with X-ray-quality.</p> <p>Suitable for butt and fillet welding of hulls, storage tanks, water wall panels, mechanical and constructional steel structure and bridges.</p>				
Base Materials				
SA 516-Gr.60, Gr. 65, IS 2062, Gr. A, Gr. B, A 36, SA 106 Gr. B, S 235 JR, S275JR, S355 JR (st33, st37-2, st44-2, st52-3), P235 HG, API 5L X42-60, AH32, EH-36, A40 –F40 etc.				
Typical composition of all-weld metal (wt. - %)				
C	Si	Mn	S	P
0.04	0.35	1.18	0.03 max	0.03 max
Typical 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 Test Values (J)
	MPa	MPa	%	-20 °C
As welded	490	580	25	≥ 27
Operating data				
Position 	Polarity =+ / DCEP	Shielding Gas : 100% CO ₂	Ø(mm)	Amps
			1.20	120 - 280
			1.60	160 - 400
Packaging Aluminium foil vacuum packing.		Size(mm)	Kg/Spool	
		1.20	15.0	
		1.60	15.0	