



Product Data Sheet

T 'Tubular cored electrode arc welding'

Weld 71T-1

Prepared by Neil Farrow	Qualified by Tero Tolonen	Approved by Neil Farrow	Reg no EN006667	Cancelling EN006520	Reg date 2015-03-27	Page 1 (2)
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REASON FOR ISSUE

Approvals updated

GENERAL

A multi-purpose all positional rutile cored wire for use with CO2 shielding gas.

Shielding Gas: C1 (EN ISO 14175)

Alloy Type: C Mn

Polarity: DC+

Fill Type: Rutile

CLASSIFICATIONS Weld Metal

SFA/AWS A5.20 E71T-1C H8
JIS Z 3313 T49J0T1-1CA-U

APPROVALS

ABS 3YSA H10
BV S3YM H10
CCS 3YSH10
CWB CSA W48-06
E491T-1-H8
DNV III YMS (H10)
GL 3YH10S
LR 3Y H10
RS 3Y40MS H10

CHEMICAL COMPOSITION

All Weld Metal (%)

	Min	Max
C		0.09
Si	0.3	0.6
Mn	1.00	1.50
P		0.03
S		0.03
Cr		0.2
Ni		0.5
Mo		0.2
V		0.08
Cu		0.3

MECHANICAL PROPERTIES OF WELD METAL

All Weld Metal

Properties	As welded	
	Min	Max
Rp0.2 (MPa)	400	
Rm (MPa)	490	660
A4 (%)	22	
Charpy V at -20°C (J)	47	



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ECONOMICS & CURRENT DATA

Dimension (mm) Ø	Current (A)		W Nom	η Nom	H		Feed			U Min	Max
	Min	Max			Min	Max	Min	Max	Min		
1.2	250	310	20	88	4,2	5,8	11,5	15,9	27		33
1.4	250	370	20	88	3,5	5,8	7,1	11,8	27		37
1.6	250	370	20	87	3,1	5,4	4,8	8,9	27		36

W = Gas consumption (l / min)

η = Recovery, g weld metal / 100g wire (%)

H = Deposit rate (kg weld metal / hour arc time)

Feed = Feeding rate (m/min)

U = Arc voltage (V)