

## WE-71T

AS/NZS ISO 17632-B-T 49 3 T1-1 M21/C1 A-U H5

AWS A5.20 E71T-1M/9M/1C/9C-H4

### Seamless flux cored wire for welding Mild Steel and 490mPa High Tensile Strength Steel with CO<sub>2</sub> or Argon/CO<sub>2</sub> mixed shielding gas.

#### GENERAL DESCRIPTION

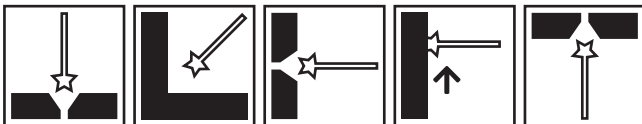
WE-71T is a seamless, rutile flux cored wire for welding with either 100% CO<sub>2</sub> shielding gas or 80% Argon / 20% CO<sub>2</sub> mixed shielding gas. Due to the unique seamless design, the wire has an extremely low diffusible hydrogen content, typical 2.1ml/100g weld metal, and superior crack resistance.

Highly efficient weldability in all positions, very good penetration in vertical down. The double copper coated

surface and consistently exact wire diameter ensures smooth wire feeding and a stable, accurate arc. This results in very little spatter and a clean smooth bead surface, with minimal wear on liners and consumables.

Weld metal shows excellent toughness in low temperature range to -30°C. Performs well in cold, damp conditions with maximum protection against porosity. WE-71T has a Grade 3 shipping approval (ABS).

#### WELDING POSITIONS



#### TYPE OF GAS FLOW

100% CO<sub>2</sub> 18-25 l/min

80% Ar-20% CO<sub>2</sub> 20-25 l/min

#### TYPICAL CHEMICAL COMPOSITION OF ALL-WELD-METAL (%)

Shielding Gas	C	Si	Mn	P	S	Ni	Cr	Mo	V	Cu
100% CO <sub>2</sub>	0.05	0.38	1.35	0.008	0.004	0.36	0.03	0.01	0.02	0.29
80% Ar / 20% CO <sub>2</sub>	0.06	0.45	1.51	0.008	0.003	0.36	0.03	0.01	0.02	0.29

**DIFFUSIBLE HYDROGEN CONTENT: ≤4 ml/100g (2.1 ml/100g typical)**

#### TYPICAL MECHANICAL PROPERTIES OF WELD METAL

Shielding Gas	Yield and Tensile Strengths			Charpy Impact Test	
	Yield MPa	Tensile MPa	Elongation %	Charpy V (J) -30°C	Charpy 2V-notch (J) -20°C
100% CO <sub>2</sub>	534	593	26	98	N/A
80% Ar / 20% CO <sub>2</sub>	575	645	26	97	90

#### GUIDANCE – AMPERE (DC+)

Wire Diameter		1.2 mm	1.4 mm	1.6 mm
Current Amp	F, H, HF	180-300	200-400	220-450
	VU, OH	180-270	200-280	200-280

#### PACKAGING INFORMATION

1.2mm x 15kg spool

1.4mm x 15kg spool

#### SHIPPING APPROVAL

ABS