Introducing WE-71T Seamless Flux Cored Wire

NEW PRODUCT!

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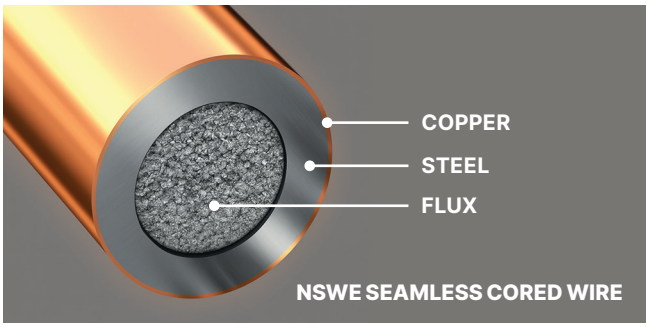
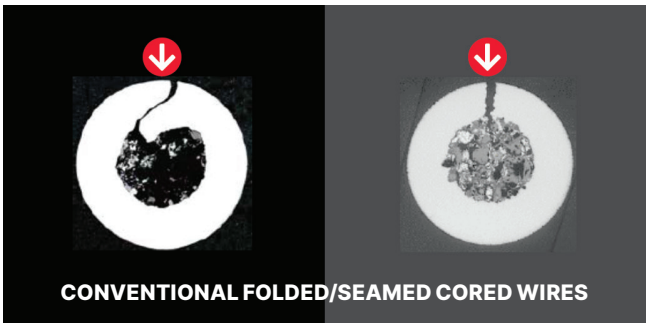
Manufactured in Japan by Nippon Steel Welding & Engineering Co. (NSWE); WE-71T seamless wire is a product of Japanese engineering excellence designed and manufactured exclusively for Welding Engineers NZ Ltd to meet the requirements of the New Zealand market.

Why Use NSWE Seamless & Copper-Coated Cored Wires?





NSWE'S Advanced Manufacturing Method:

- Horizontal flux filling process to achieve even spread of flux ingredients for consistent composition and stable welding. Commonly used vertical filling by vibration results in heavy flux elements moving lower in the wire and uneven composition affecting weld quality.
- High Temperature dehydrogenation and seam welding ensures very low diffusible hydrogen.
- Exactly engineered drawing and shaping of the wire for perfect cross-sectional symmetry.

LOW HYDROGEN CONTENT

Low diffusible hydrogen levels reduce the risk of porosity and cold cracking, improve weld quality and reduce pre- and/or post-heating requirements. The very low levels in NSWE seamless wires are maintained over time, even after storage and opening.

SUPERIOR DURABILITY & CORROSION RESISTANCE

With no seam for moisture/hydrogen to enter, the low hydrogen content remains steady even in humid or damp, cold conditions. The copper coating protects against corrosion and oxidation over time.

IMPROVED PERFORMANCE

The wire's perfect symmetry and seamless design ensure smooth, consistent feeding with no catching or oscillation. The copper coating enhances electrical contact. These features ensure precise targeting and a very stable arc, giving better penetration and fusion with less heat.

ENHANCED PRODUCTIVITY

The very stable arc and smooth wire feeding combined with reduced downtime for consumable replacement and troubleshooting, significantly increases welding efficiency and productivity.

REDUCED WEAR

The seamless design and copper coating means minimal friction. No lubrication is required so no residue build-up, and wear on liners and tips is reduced by as much as 80% compared to seamed wires. NSWE seamless wires are so smooth that they are run with V-groove drive rollers; knurled rollers are not required.

CONSISTENT HIGH WELD QUALITY

NSWE seamless wires consistently produce quality welds with excellent mechanical properties. Re-work is minimised; production is maximised.

Weld Faster. Weld Stronger. Weld Smarter.

Choose WE-71T® SEAMLESS Flux Cored Wire for high productivity, minimal rework, and significant labour cost savings. Ready to experience the best of welding? Request a sample or speak to our experts today!

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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_2 or Argon/CO_2 mixed shielding gas.

GENERAL DESCRIPTION

WE-71T is a seamless, rutile flux cored wire for welding with either 100% CO_2 shielding gas or Argon/CO_2 mixed shielding gas as classified. 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_2 18-25 l/min
15-25%CO_2/85-75% Ar 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_2	0.05	0.38	1.35	0.008	0.004	0.36	0.03	0.01	0.02	0.29
80% Ar / 20% CO_2	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_2	525	594	27	105	119
80% Ar / 20% CO_2	543	617	29	102	116

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