

Flux Cored - Welding Wire - E71T-1



- E71T-1 is an all-position rutile flux cored wire designed to be used with CO₂ gas. It can be used on all-position welds with both single and multiple pass welds on mild steel and low alloy steels
- It is widely used for shipbuilding, storage vessels, structural fabrication, machinery and piping, etc.

NOTE ON USAGE :

1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

Standard Designation to :

AWS A5.20	E71T-1
JIS Z3313	YFW -C50DR
GB	E501T-1
ABS, BV, DNV-GL, LR, RINA, NK, CCS	

Average Analysis of Wire (wt%) :

Weld Metal Analysis :

Carbon (C)	≤ 0.18
Manganese (Mn)	≤ 1.75
Silicon (Si)	≤ 0.90
Phosphorus (P)	≤ 0.030
Sulphur (S)	≤ 0.030

Mechanical Properties of all-weld metal

Yield Strength	≥ 375 N/mm ²
Tensile Strength	490 - 660 N/mm ²
Impact Strength	78 J min
(IV) (-20°C)	
Elongation	≥ 22 %

SUGGESTED WELDING PARAMETERS

Parameter	Diameter 1.2
Voltage (Volt)	25 ~ 40
Current (Amp)	130 ~ 300
W.F.S. (cm/min)	460 ~ 1000
Stickout (mm)	15 ~ 20
Flow Rate (l / min)	15 ~ 25

Item Code	Item Name	Pack	Roll	Kg
301.01.001	Flux Cored Wire E71T-1, Ø 1.2 mm	1 box	1 roll	15 Kg
		1 pallet	72 rolls	1080 Kg

Certificate

