

ULTRA 71T-1

FLUX CORED WIRE

AWS A/SFA 5.20
E71T-1C

CLASSIFICATION:

- EN ISO 17632 A
- T:42 2 R C/M 2
- T422 PC12
- IS 15769
- ET531RC-9

TYPICAL APPLICATIONS:

- Storage tanks, Structural steel
- General carbon steel fabrication
- Chemical plant machinery, Hulls.
- Bridges, Shipbuilding, Towers, Cranes
- Construction equipment, Farm machinery, Rolling stocks
- Welding of C-Mn steel with tensile strength up to

KEY FEATURES:

- All position capability
- Radiographic quality weld
- Rutile type gas shielded FCW wire
- Easy slag removal, smooth weld bead
- Suitable for high quality single and multi pass welds.
- Low fumes, Minimal spatters with high deposition

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL WT (%):

C – 0.06	Mn – 1.4	Si – 0.4
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MECHANICAL PROPERTIES OF ALL WELD METAL:

Condition	UTS, Mpa	YS at 0.2% offset, Mpa	EL%	CVN Impact, J at -
Typical	570 490	480	26 22	60
Specification	min	390 min	min	47 min

PARAMETERS & PACKING DATA:

Ø x L mm	Amperage, A
1.2	130-300
1.6	200-380

DCEP(Electrode Positive)

Use 1-2 volts lower when using mix shielding gas

Available in Vacuum Pack of 15 kg wire layer wounded on Plastic Spool.



DCEP

Electrode Positive

All positions except vertical down



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