

ULTRA 71T-1

FLUX CORED WIRE

AWS A/SFA 5.20
E71T-1M

CLASSIFICATION:

- EN ISO 17632 A
- T 42 2 M / M 2
- T481T2-1CH
- TS 6360

TYPICAL APPLICATIONS:

- Storage tanks, Structural steel
- General carbon steel fabrication
- Chemical plant machinery, Hulls Bridges, Shipbuilding, Towers, Cranes
- Construction equipment manufacturing • Welding of C-Mn steel with tensile strength up to 500 Mpa

KEY FEATURES:

- All position capability
- Radiographic quality weld
- Rutile type gas shielded FCW wire
- Easy slag removal, smooth weld bead
- Suitable for high quality multi-pass welds
- Low fumes, minimal spatter with high deposition rate

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 -
As Welded	570	480	22	71

PARAMETERS & PACKING DATA:

Ø x L mm	Amperage, A
1.2	130-300

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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mix shielding gas**