

ES 71T1M

FCAW

ESWECO
The Art of Welding

Type Rutile

E71T-1, E71T-1M

Description

ES 71T1M is a flux-cored, tubular wire designed as a truly all-positional, general-purpose wire for welding mild and medium tensile steels up to 510 MPa tensile strength. Using either Ar/CO₂ or CO₂ as the shielding gas, the 1.2 and 1.4 mm sizes can be used in the vertical position on spray transfer providing for maximum deposition and time savings. Weld pool control is easy both vertically up and downwards and slag removal is rapid. ES 71T1M is designed for a wide range of applications especially where manipulation of the work is impractical.

Shielding gas
Ar/20%CO₂ or CO₂.

Current

DC+

Classifications

SFA/AWS A5.20	E71T-1, E71T-1M
EN 758:1997	T 46 2 P M 2 H5, T 46 2 P C 2 H5

Typical all weld metal composition, %

C	Si	Mn
0.05	0.3	1.3

Typical mech. Properties all weld metal

Yield stress, MPa	520
Tensile strength, MPa	580
Elongation, %	28

Charpy V

Test temps, °C	Impact values, J
-20	140

Welding parameters

Diameter, mm	Welding current, A	Arc voltage, V
1.2	110-300	21-32
1.4	130-320	22-32
1.6	150-360	24-34