

ES 71T1C

FCAW

ESWECO
The Art of Welding

Type Rutile

E71T-1, E71T-1M

Description

ES 71T1C is a flux-cored, tubular wire for all-positional welding using either Ar/CO₂ or CO₂. The wire is suitable for all mild and medium tensile structural steels. The running characteristics are exceptional, using the spray mode of transfer, and this applies equally to both shielding gases. ES 71T1C is also universally approved to grade 3 by all major authorities.

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 H10, T 46 2 P C 2 H10

Typical all weld metal composition, %

C	Si	Mn
0.05	0.5	1.3

Typical mech. Properties all weld metal

Yield stress, MPa	530
Tensile strength, MPa	580
Elongation, %	26

Charpy V

Test temps, °C	Impact values, J
+20	120

Approvals

ABS	3SA 3YSA Ar/CO ₂ & CO ₂
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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