Inweld 71T1-9C/9M

AWS A5.20 E71T-1C/1M,9C/9M

Typical Chemical Composition of All-Weld-Metal(%) (Shielding gas : CO2)

C	Mn	Si	P	S
0.04	1.35	0.55	0.02	0.01

Description and Applications

Designed for welding of 50kgf/mm² high tensile steel. All position welding of building, shipbuilding, bridges, machineries, vehicles, offshore structures and general fabrications.

The most widely used rutile type flux cored wire for all position welding.

As deposition rate is higher than solid wire and manual metal arc electrode, highly efficient welding can be performed.

Provides low fume generation and has good impact strength at low temperatures.

Proper preheating(50~150ºC) and interpass temperature must be used in order to release diffusible hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.

One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.

Shielding gas should be used 100% CO2 or Ar+20~25% CO2.

Sizes Available and Recommended Currents (DC +)

Position	Dia	0.045”
F		180~340A
HF	Amp	180~340A
V-up, OH		120~220A

Typical Mechanical Properties of All-Weld-Meta (Shielding gas : CO2)

Y.S MPa	T.S MPa	EL(%)	CVN-Impact Value J (-20ºC)
521	576	28	75

Welding positions



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