Inweld 71T-1M/C

AWS A5.20 E71T-1M/C

Chemical Composition of Inweld Fusion Flow 71T-1M/C

Fe	C	Cr	Ni	Mo	Mn	Si	P	V	N	Cu
Balance	0.12	0.20	0.30	0.30	1.75	0.90	0.03	0.08	---	0.350

Single values are maximum unless otherwise specified.

Description and Applications

A gas shielded, flux cored electrode intended for single and multiple pass welding of carbon and low alloy steels. 71T-1 exhibits excellent weld joint penetration and virtually eliminates lack of fusion problems. Weld-ability is excellent in all positions. Slag coverage is complete, and the slag removes easily and clean. Weld beads are radio-graphically sound. Typical applications include: general purpose flux cored welding of steel; structural steels; farm and mill machinery; construction and fab equipment; carbon steel fabrication.

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

Typical Weld Metal Properties

	AWS Spec
Average As-Welded Brinell Hardness: Tensile Strength:	83,000 psi
Yield Strength:	71,000 psi
Elongation:	25%
Charpy V-Notch at 0°F:	20 ft-lbs

Recommended Parameters

FCAW (DCEP – Electrode+)

Diameter	Wire Feed Speed	Amperage	Voltage	Deposition Rate	Wire Stick-Out
0.035”	160-425	100-200	22-25	3.5-9.5	3/4”
0.045“	140-400	120-250	23-26	4.0-10.5 lbs	3/4”
0.052”	120-395	120-395	23-27	3.5-11.5 lbs	3/4-1”
1/16”	100-300	100-300	25-28	4.5-11.5 lbs	3/4-1”

Welding Position



INWELDCORPORATION.COM

Pennsylvania
3962 Portland Street
Coplay, PA 18037

Phone: 800.346.5368
Fax: 877.346.5368

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Texas
9300 Lawndale St.
Houston, TX 77012