

## ❖ Product Description

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|--|---|
| I. Gas shielded, rutile type wire          | V. Weld metal consistently free of inclusion, porosity. |
| II. Low fumes, very less spatter           | VI. Slag removed easily                                 |
| III. The rate of deposition is high        | VII. Radiographic weld quality                          |
| IV. Suitable for single and multipass weld |   |

## ❖ Range of Application

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|--|---|
| I. Extremely suitable for welding of C-Mn with high tensile strength | IV. Chemical plant, machinery, hull                         |
| II. For joining ASTM A-36/36M, A-283/283M etc                        | V. Storage tanks, structural steels, earth moving equipment |
| III. Finds application in bridges, cranes, towers etc                | VI. For general carbon steel fabrication                    |

## ❖ Classification

- AWS/SFA 5.20 E71T-1M

## ❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cr	Ni	Mo	V	Cu
E71T-1M	Min	-	-	-	-	-	-	-	-	-	-
	Max	0.12	1.75	0.90	0.03	0.03	0.20	0.50	0.30	0.08	0.35

## ❖ Mechanical Properties of all weld metal

Condition	UTS, Mpa	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -29°C
As Welded	480-655	400	22	27

## ❖ Wire Size & Welding Position

- Diameter in mm- 1.2, 1.6
- Weld Position- All position

## ❖ Current & Gas Flow

- DCEP; 18-25lit/min

## ❖ Packaging

- Standard packaging in 15kg Spool form

### Special Notes: -

- (1) All the value above mentioned are typical values.
- (2) Usually all chemistry and mechanical properties will depend on actual wire chemistry and arc voltage used for welding.

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