

❖ Product Description

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|---|-------------------------------------|
| I. Gas shielded, basic FCW wire | IV. Excellent mechanical properties |
| II. Low fumes, very less spatter | V. Stable arc and easy slag removal |
| III. Good resistance to crack, welds are tough especially when welding high steels with high carbon content | VI. All position accessibility |
| | VII. Radiographic weld quality |

❖ Range of Application

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| I. Extremely good for welding structural and boiler quality steels with high tensile strength | III. Chemical plant, machinery, hull |
| II. Finds application in heavy sections in pressure vessels, construction equipment, off-shore bridges | IV. Storage tanks, structural steels |
| | V. Suitable for IS 226, IS 2002, IS 2062, DIN 17115 HIV |

❖ Classification

- AWS/SFA 5.20 E71T-5C

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cr	Ni	Mo	V	Cu
E71T-5C	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 @ -30°C
As Welded	450-655	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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