

❖ Product Description

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| I. Gas shielded, basic FCW wire | IV. Quick freeze slag |
| II. Low fumes, very less spatter | V. All position accessibility |
| III. Designed to handle poor fit-up on heavy wall tubes and gaps up to 9.5mm | VI. Radiographic weld quality |

❖ Range of Application

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|---|-------------------------|
| I. Extremely good for welding general plate fabrication, hull plate and stiffener welding on ships and barges | III. Structural welding |
| II. Finds application in heavy sections in pressure vessels, construction equipment, off-shore bridges | IV. Storage tanks |

❖ Classification

- AWS/SFA 5.20 E71T-8

❖ % Chemical Composition

Type of Wire		C	Mn	Si	S	P	Cr	Ni	Mo	V	Al	Cu
E71T-8	Min	-	-	-	-	-	-	-	-	-	-	-
	Max	0.30	1.75	0.60	0.03	0.03	0.20	0.50	0.30	0.08	1.8	0.35

❖ Mechanical Properties of all weld metal

Condition	UTS, MPa	YS, MPa (Min)	% Elongation	Charphy "v" Notch Impact @ -30°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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