

## Key Facts

- General purpose E71T-1 Flux core wire
- Designed for Co2 gas for lower operating cost
- Smooth welding arc
- Low spatter levels

## Description

A general purpose, precision layer wound, flux cored mild steel MIG wire for use with CO<sub>2</sub> gas. Recommended for single or multiple pass welding of mild and carbon steels. Welding positions; all positions

## Classifications, Approvals & Conformances

**AWS A5.20, E71T-1**

ABS - American Bureau of Shipping  
DNV - Det Norske Veritas  
Lloyd's Register of Shipping  
JIS Z3313, YFW -C50DR  
DIN 8559 SGR-CY 4232

## Recommended Shielding Gas

CO<sub>2</sub> or Ar/CO<sub>2</sub> 10-15 Lit./min.  
100%CO<sub>2</sub> ora75–25% Argon / CO<sub>2</sub> mixture

## Welding Positions

All positions except vertical down



## Applications

Most suitable in production or general fabrication where highest deposition rates and low spatter is required including farm machinery, construction equipment and carbon steel fabrication.

- Structural steel fabrication
- Construction of rural equipment
- Pressure vessels
- Earth moving equipment

## Typical Wire Analysis

C - Carbon	Mn - Manganese	Si - Silicon	Cr - Chromium
< 0.18	< 1.75	< 0.90	< 0.20
Ni - Nickel	Mo - Molybdenum	S - Sulphur	P - Phosphorus
< 0.50	< 0.30	< 0.03	< 0.03
Cu - Copper	V - Vanadium		
< 0.35	< 0.08		

## Typical Weld Mechanical Properties

<b>0.2% Proof Stress:</b>	> 400N/mm <sup>2</sup>
<b>Tensile Strength:</b>	490 – 670N/mm <sup>2</sup>
<b>Elongation:</b>	> 22%
<b>Diffusible Hydrogen:</b>	6.5ppm
<b>Impact Strength:</b>	27J @ -18°C

## Packaging & Ordering Information

Size	Packet	Part Number
1.2mm	15kg	200250
1.6mm	15kg	200251

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary from model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products this is entirely up to the user's ability.