

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. Weldability 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.

Typical Weld Metal Properties

	<u>AWS Spec</u>
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+)

<u>Diameter</u>	<u>Wire Feed Speed</u>	<u>Amperage</u>	<u>Voltage</u>	<u>Wire Stick-Out</u>
0.035"	350	160	22-25	3/4"
0.045"	300	200	23-26	3/4"
0.052"	250	210	23-27	3/4-1"
1/16"	200	250	25-28	3/4-1"

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