

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. Weld-ability 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.

Shielding gas should be used 100%CO₂ or Ar+20~25% CO₂.

Typical Weld Metal Properties

AWS Spec

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"

Welding Position



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