

Inweld Fusion Flow 71T-GS

AWS A5.20 E71T-GS

Chemical Composition of Inweld Fusion Flow 71T-GS

Fe	C	Cr	Ni	Mo	Mn	Si	P	S	V	Cu
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Values agreed upon by Inweld manufacturing. Ask your local Inweld representative for values & certifications if needed.

Description and Applications

This classification is for single pass electrodes that have usability characteristics not covered by any presently defined classification. Except for the tensile strength, which is specified, the requirements for this class are not specified. They are agreed upon by the purchaser and supplier. This alloy is EXCELLENT for hobbyists and less skillful welders. This wire is specifically formulated to produce sound welds on galvanized in all positions. Low penetration characteristics make this an excellent choice for thin gauge steels, as well as sheet metals. The arc is smooth and quiet with virtually no spatter. Ideal for use on small, single phase welders in the 130-190 amp range. Especially suited for outdoor welding, as no gas shielding is required. 71T-GS is a gasless wire for galvanized and aluminized steels.

Typical Weld Metal Properties

	<u>AWS Spec</u>
Tensile Strength:	86,000 psi
Yield Strength:	
Elongation:	
V-notch Impact at 0 F:	44 ft-lbs.

Recommended Parameters

FCAW

<u>Wire Diameter</u>	<u>Voltage</u>	<u>Amperage</u>
0.030"		40-100
0.035"		100-130
0.045"		140-180
1/16"		175-300
5/64"		190-310

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