



Standards:

BOHLER E 71T-1C/1M

AWS A5.20 : E71-T1C/1M

GMAW rutile flux cored wire.

Application field

Rutile flux cored wire with fast freezing slag. Excellent welding characteristics in all positions. Very good mechanical properties, easy slag removability, low spatter level, smooth and well shaped beads with x-ray-quality. Is applicable in out-of-position welding, which results in cost reduction due to higher productivity and less time for postweld cleaning. Particularly suited for welding prime coated plates in shipbuilding, steel and bridge constructions.

Base Materials

St 34 - St 60, A36, A516 Gr 70
DIN St-W-TT St E 26-36
HI-HIV; 17 Mn4
St 35 -St 55; St 34.7 - St 53.7;
St 35.8 - St 45.8
Quality A-E
GS 38 - GS 52

Weld metal analysis in % with CO₂ 100%

C	Mn	Si	P	S
0.12	1.75	0.9	0.03	0.03

Mechanical properties of the weld metal

Tensile strength MPa	Yield strength (0.2%) MPa	Impact strength K_v joule	Elongation (l = 4d) %
>490	>390	>27 J (-20°C)	>22

Weld metal analysis in % with Ar/CO₂ 75 /25%

C	Mn	Si	P	S
0.12	1.75	0.9	0.03	0.03

Mechanical properties of the weld metal

Tensile strength MPa	Yield strength (0.2%) MPa	Impact strength K_v joule	Elongation (l = 4d) %
>490	>390	>27 J (-20°C)	>22

Current adjustment

Diameter (mm)	Current (A)	Voltage (V)	Travel Speed m/min.	Stick-out (mm)	Shielding gas
1.2	140-200	24-30	1.2-4.0	35-40	CO ₂ 100%
1.6	160-230	24-30	2.0-5.0	35-40	CO ₂ 100%

Availability: Spool 15 Kg approx.