

# Flux cored welding wire - T71C/T71M

EN ISO 17632-A-T 42 4 R C/M 2 H10  
AWS A5.20 E71T-1C/1M

Rutile flux-cored wire is suitable for welding in all positions of universal application. It is suitable for spray arc welding and offers excellent weldability. It is recommended for ship constructions.

#### Approvals:

|     |              |
|-----|--------------|
| TÜV | 12545        |
| DNV | III YMS(H10) |
| CE  | 13479        |
| GL  | 3YH10S       |
| LR  | 3YS          |
| BV  | SA3YH10      |
| ABS | 3YSAH10      |

#### Core type:

Rutile

#### Shielding gas (EN ISO 14175):

M21, C1

#### Deposition efficiency:

ca. 85%

#### Welding current:

=(+)

#### Hydrogen content:

< 10ml/100g of weld

#### Other data:

ø 1,6 only in PA, PB positions

#### Welding positions:



Product no

|      |                     |          |                     |
|------|---------------------|----------|---------------------|
| ø mm | 1,2 CO <sub>2</sub> | 1,2 M    | 1,4 CO <sub>2</sub> |
| Code | T71C.020            | T71M.021 | T71C.133            |

Typical Chemical composition of the weld metal (%)

| Gas | C    | Si   | Mn   |
|-----|------|------|------|
| C1  | 0,05 | 0,55 | 1,25 |
| M21 | 0,09 | 0,38 | 1,75 |

Typical mechanical properties of the weld metal

| Test method | Condition | Gas | R <sub>m</sub><br>MPa | R <sub>eL</sub><br>MPa | A <sub>5</sub><br>% | KV (J)/°C |
|-------------|-----------|-----|-----------------------|------------------------|---------------------|-----------|
|             |           |     |                       |                        |                     | -20       |
| EN          | TZ0       | C1  | 588                   | 497                    | 27                  | 110       |

TZ0 - after welding

Technological parameters

| ø d  | Welding current | Arc voltage | Feed speed | Weld metal efficiency |
|------|-----------------|-------------|------------|-----------------------|
| (mm) | (A)             | (V)         | (m/min)    | (kg/h)                |
| 1,2  | 110 - 300       | 21 - 32     | 3,2 - 14,0 | 1,3 - 5,8             |
| 1,4  | 130 - 320       | 22 - 32     | 3,0 - 12,5 | 1,4 - 6,3             |