



71T1

Specifications / Certifications:

AWS A5.20 E71T-1C/1M
ASME SFA A5.20

Features

- Produces a fast freezing slag that facilitates out of position welds
- Optimized to minimize clean up time
- Slag is easy to remove
- Low spatter provides easy post weld cleaning
- Smooth spray transfer and outstanding arc stability
- Excellent weldability at low and high current settings

Applications

- Designed for welding mild and medium carbon steels in all positions
- Structural Steel
- Heavy Equipment
- Railcar Construction
- Mining Machinery
- General Fabrication

Technical Specifications

Recommended GMAW Weld Parameters:

DCEP					
Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO ₂ (cfh)
0.035"	275-780	130-260	23-30	3/8" – 3/4"	35-40
0.045"	200-600	150-335	22-33	1/2" – 1"	35-45
0.052"	150-600	140-390	19-35	1/2" – 1"	40-50
1/16"	150-490	150-475	23-38	1/2" – 1"	40-50
3/32"	110-275	300-550	25-34	3/4" – 1 1/4"	40-50

Typical Chemical Composition:

Chemical	C	Mn	Si	P	S
	0.12 max	1.75 max	0.90 max	0.030 max	0.030 max

Typical Mechanical Properties:

Tensile Strength (psi)	Yield Strength (psi)	Elongation
70,000 -95,000 psi	58,000 min psi	22% min

Diameters & Packages			
Diameter		Lbs	Pkg
0.030"	1/32"	2	Spool
		10	Spool
0.035"	7/200"	2	Spool
		10	Spool
		11	Spool
		25	Spool
		33	Spool
0.045"	3/64"	2	Spool
		10	Spool
		11	Spool
		15	Spool
		33	Spool
		44	Spool
		500	Drum
0.052"	1/20"	550	Drum
		15	Spool
		33	Spool
		44	Spool
		60	Coil
		500	Drum
0.062"	1/16"	11	Spool
		33	Spool
		44	Spool
		60	Coil
		550	Drum
0.093"	3/32"	60	Coil