



# AFM71T-1 BAKED

**Certifications:**  
AWS A5.20  
AWS A5.36

## Features

- Smooth spray transfer and outstanding arc stability.
- Excellent weldability at low and high current settings.
- Offers low spatter, easy slag removal, high x-ray safety, and a smooth bead surface.

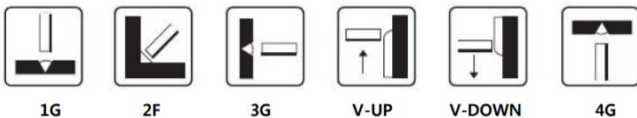
## Applications

- Designed for welding high tensile strength steels in all positions.

## Usage

- Use 100% CO<sub>2</sub> gas or AR + 20~25% CO<sub>2</sub>
- Keep the distance between the tip and the base metal at 15~25 mm.

## Welding Positions



## Technical Specifications

### Typical Chemical Composition:

Chemical	C	Mn	Si	P	S	Cu
	0.12 max	1.75 max	0.90 max	0.03 max	0.03 max	0.35 max

### Recommended Weld Parameters:

Diameter	Volts	Amps
0.045"	Flat: 24-36 Horizontal Fillet: 24-36 Vertical Up: 24-30	Flat: 180-340 Horizontal Fillet: 180-340 Vertical Up: 140-260
0.052"	Flat: 26-38 Horizontal Fillet: 26-38 Vertical Up: 26-30	Flat: 200-360 Horizontal Fillet: 200-360 Vertical Up: 160-280
0.062"	Flat: 26-42 Horizontal Fillet: 26-42 Vertical Up: 26-32	Flat: 200-420 Horizontal Fillet: 200-420 Vertical Up: 200-300

### Typical Mechanical Properties:

Tensile Strength	Yield Strength	Elongation
71,000-95,000 psi	58,000 psi	22%