



71T-9

Specifications / Certifications:

AWS A5.20 E71T-9C/9M

Features

- Excellent mechanical properties
- Easy slag removal
- Low spatter
- Smooth bead surface
- High x-ray safety

Applications

- High tensile steel
- Ships
- Vehicles
- Bridges
- Machinery

Technical Specifications

- Use 100% CO₂ gas or Ar+20-25% CO₂ gas.
- The optimum flow of CO₂ for shielding is 20-25 l/min.
- Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 6.56 ft/sec (2m/sec) and more.
- Keep the distance between tip & base metal at 0.59-0.98 in (15-25 mm).
- For multi-layer welding, keep preheat and inter-pass temperature below 302°F (150°C)

Typical Chemical Composition:

Chemical	C	Mn	Si	P	S	Cu
71T-9	0.03	1.24	0.38	0.014	0.009	0.01
AWS	0.12 max	1.75 max	0.90 max	0.03 max	0.03 max	0.35 max

Typical Mechanical Properties:

	Tensile Strength (psi)	Yield Strength (psi)	Elongation	Impact Value (J)	Heat Treatment
AWS	71,068-97,175 psi	56,564 min psi	22% min	27 min	
71T-9	84,702 psi	75,419 psi	29%	130	AW
	79,770 psi	71,068 psi	31%	110	PWHT (620°C X 2Hr)

Recommended GMAW Weld Parameters:

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

Diameters & Packages

Diameter		Lbs	Pkg
0.045" Unbaked	3/64"	33	Spool
		44	Spool
0.045" Baked	3/64"	44	Spool
0.062" Unbaked	1/16"	44	Spool

Welding positions



1G



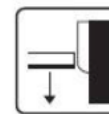
2F



3G



V-UP



V-DOWN



4G