Weld 71T-1

A multi-purpose all positional rutile cored wire for use with either CO2 or mixed Ar/CO2 shielding gas.

Specifications	
Classifications	EN ISO 17632-B : T 492T1-1C1-AUH10 EN ISO 17632-B : T 492T1-1M21-AUH10 SFA/AWS A5.20 : E71T-1C H8 JIS Z 3313 : T49J0T1-1CA-U EN ISO 17632-A : T 46 2 P C1 1 H10
Approvals	ABS : 3YSA H10 BKI : 3YH10SM BV : S3YM H10 CCS : 3YSH10 CE : EN 13479 CWB : CSA W48-06 E491T-1-H8 DNV-GL : III YMS(H10) FBTS : E71T-1C LR : 3YS H10 NAKS/HAKC : 1.2MM RS : 3Y40MS H10

Welding Current	DC+
Alloy Type	C Mn

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
C1			
As Welded	490 MPa	556 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
C1		
As Welded	-20 °C	100 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
C1		
0.05	1.36	0.45

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	140-300 A	24-33 V	11.5-15.9 m/min	4.2-5.8 kg/h
1.4 mm	160-360 A	24-37 V	7.1-11.8 m/min	3.5-5.8 kg/h
1.6 mm	170-410 A	24-36 V	4.8-8.9 m/min	3.1-5.4 kg/h

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