CHIYODA

フラックス入りワイヤ

E71T-1C

FLUX CORED ARC WELDING WIRES (FCAW)

ISO 9001 2016

CLASSIFICATION
AWS A5.20 : E71T-1C JIS Z3313 LT • E501 (E71T-1) EN 13479:2017

FEATURES & APPLICATIONS

E71T-1C shows excellent welding performance and higher efficiency in welding. All Position welding could be applied. It is widely used in structures fabricated by equivalent mild steels and 490MPa grade high tensile strength steels, such as ships, pressure vessels, machineries, petrochemical industry equipments, bridges and so on.

PACKAGING DATA

Diameter	Standard Package	Standard Pallet
1.0mm	15kg / spool	1080kg (72 Spools)
1.2mm	15kg / spool	1080kg (72 Spools)
1.6mm	15kg / spool	1080kg (72 Spools)

CHIYODA

- LOW SPATTER
- BEAUTIFUL BEADS
- SMOOTH SURFACE
- EASY SLAG REMOVAL

Applicable Welding Position

Chemical Composition of Deposited Metal

	C	Mn	Si	S	P
Standard	0.05	1.37	0.35	0.007	0.013

Mechanical Properties of Deposited Metal (AW)

	Yield Strength ReH (Mpa)	Tensile Strength Rm (Mpa)	Elongation A4 (%)	Impact Value (J)	Shield Gas
				-20°C	CO2
Standard	≥400	≥480	≥27	≥27	Purity ≥ 99.98%
Typical	480	550	28	110,124,107	

Recommended Current (DC)

Diameter (mm)		1.2	1.4	1.6
Welding Position & Current (A)	F	120-300	150-380	180-430
	HF	120-280	150-320	180-380
	V,OH	120-260	150-270	180-280
	H	120-280	150-320	180-330
	VD	200-280	220-300	250-300

Approvals

Institute	CCS	LR	ABS	BV	NK	KR

Notice:
1) The flow rate of shield gas should within 20L-25L/min in welding.
2) The wire exention should be 15mm-25mm.
3) The surfaces to be welded must be cleaned away impurities of oil contamination, rust, moisture and so on.
4) The welding conditions mentioned above for reference only and it is better to do a welding procedure qualification according to project before put it into formal welding.