



PRODUCT DATA SHEET

FLUX CORED GAS SHIELDED WIRES

WCD 7025

Austfil 71T



SUMMARY

- > All Purpose Rutile Flux Cored Wire
- > For Both Single or Multiple Pass Welds
- > All Positional Wire
- > Formulated Exclusively For CO₂ Gas

CLASSIFICATION

- > AS/NZS ISO 17632-B - T492T1-1CA-UH10
- > AWS A5.20: E71T-1 H8

DESCRIPTION AND APPLICATION

Austfil 71T is a rutile flux cored wire designed for excellent performance in all positional fillet and butt-welding applications. Austfil 71T is formulated exclusively for use with cost effective CO₂ shielding gas.

Austfil 71T is recommended for general purpose all positional welding of mild, carbon and carbon-manganese steels where excellent weld profile and penetration is required. Suitable for applications such as storage tanks, structural fabrication, bridge construction, machinery and earthmoving equipment. Suitable for AS/NZS 1554.5 of the structural code; Part 5: Welding of the steel structures subject to high levels of fatigue loading.

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	150 - 300	25 - 32
1.6	200 - 350	25 - 32

Welding Current DC +

Welding parameters shown above are for DC electrode positive using 100% CO₂ shielding gas at a flow rate of 15-20 litres/minute.

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

SHIPPING APPROVAL

LR 3S, 3YS

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	S	P	Fe
0.03	1.28	0.44	0.01	0.013	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	CO ₂
Yield Stress	531 MPa
Tensile Strength	580 MPa
Elongation	26%
CVN Impact Values	93J @ -20°C

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	15kg Spool	71T112S
1.6	15kg Spool	71T116S

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