

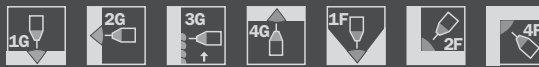


PRODUCT DATA SHEET

FLUX CORED GAS SHIELDED WIRES

WCD 7020

Austfil 71T-1M



SUMMARY

- > Rutile Type Flux Cored Joining Wire, Micro Alloyed
- > Formulated Exclusively for use with Ar/CO₂ Shielding Gas Mixtures
- > Excellent Operator Appeal "Smooth Spray Arc Transfer"
- > Versatile All Positional Capabilities
- > Grade 3 Weld Metal Impact Properties

CLASSIFICATION

- > AS/NZS ISO 17632-B - T493T1-1MA-UH10
- > AWS A5.20: E71T-1M

DESCRIPTION AND APPLICATION

An all positional rutile micro alloyed type flux cored welding wire specifically formulated for optimum performance using Ar/CO₂ shielding gas mixtures.

The exceptionally smooth arc performance produces a superb weld for single or multipass welding with low spatter losses in all positions and applications (except vertical down). Austfil 71T-1M is recommended for the welding of mild, carbon and carbon-manganese medium steels where good impact properties at -30 °C are required.

This high deposition wire offers excellent operator appeal for general steel fabrications and constructions such as plate sections, beams, girders, truck chassis bodies, shipbuilding, earth moving equipment, storage tanks, bridge construction etc.

Recommended shielding gases are: Argon + 18-25% CO₂

OPERATIONAL DATA

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLTAGE RANGE *(V)
1.2	170 - 300	24 - 30

Recommended electrical stick out is 15-20mm.
Welding Current DC +
*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	B	Fe
0.04	1.15	0.35	0.004	0.013	0.004	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	Ar+20% CO ₂
Yield Stress	511 MPa
Tensile Strength	566 MPa
Elongation	32%
CVN Impact Values	131J @ -20°C, 108J @ -30°C

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PALLET SIZE (KG)	PART NO.
1.2	15kg Spool	1080	71T1M12S

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Issue CA - December 2014



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