



71T-12MJ Carbon Steel Flux-Cored Wire

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com

Quality Management System
in accordance with
ISO 9001:2000
Cert # 05-R0925



ALLOY DESCRIPTION AND APPLICATION:

71T-12MJ is a flux cored all-position wire designed for single or multi pass welding of mild and carbon steels where excellent impact toughness values at low temperatures are required. This wire having outstanding operating ranges gives you a smooth arc transfer, low spatter, with a high deposition rate and easily removal slag. This all-position wire has excellent feeding and low fume generation using 75% Argon 25% CO₂ making it a good choice for mild steel and higher strengths steels.

TYPICAL FCAW WELDING PROCEDURES; DCEP

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	Ar &CO ₂ (cfh)
0.045	225-425	165-265	23-29	1/2-3/4"	35-45

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES; Heat # 70815111

	AWS Spec.	71T-12MJ		AWS Spec	71T-12MJ
Carbon	0.12 max	0.048	Tensile Strength (psi)	70-90,000	89,000
Manganese	1.60 max	1.48	Yield Strength (psi)	58,000 min.	83,000
Silicon	0.90 max	0.53	Elongation in 2"	22 % min.	23%
Nickel	0.50 max	0.44	Charpy V-notch at -40°F	20 ft·lbs min.	28.2 ft·lbs
Phosphorus	0.030 max.	0.013	Copper	0.35 max	0.01
Sulfur	0.030 max	0.007	Molybdenum	0.30 max	0.02
Chromium	0.20 max	0.01	Vanadium	0.08 max	0.01

AVAILABLE SIZES: TCF 71T-12MJ= Spools of .045

SPECIFICATIONS; ANSI/AWS A5.20 E71T-12MJ
ASME SFA A5.20 E71T-12MJ



10-2007 DC

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