71T-1 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

American Welding Society
Sustaining Company Member

ALLOY DESCRIPTION AND APPLICATION:

71T-1 is a flux cored wire designed for single or multi pass welding having a smooth arc transfer, low spatter, flat to slightly convex bead contour, with a high deposition rate and easily removal slag. This all-position wire has excellent feeding and low fume generation using 100% CO_2 making it a good choice for mild steel and higher strengths steels. Argon - CO_2 gases may be used if tested with application.

TYPICAL FCAW WELDING PROCEDURES; DCEP OPTIMUM IN BOLD (FLAT)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO_2 (cfh)
0.035	275-**580**-780	130-**200**-260	23-**27**-30	3/8-3/4”	35-40
0.045	200-**450**-600	150-**250**-335	22-**29**-33	1/2-1”	35-45
0.052	150-**400**-600	140-**275**-390	19-**28**-35	1/2-1”	40-50
1/16”	150-**330**-490	150-**330**-475	23-**30**-38	1/2-1”	40-50
5/64”	120-**250**-300	250-**385**-450	26-**29**-32	3/4-1 1/4"	40-50
3/32”	110-**185**-275	300-**425**-550	25-**29**-34	3/4-1 1/4"	40-50

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

TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

	AWS Spec.	U.S. ALLOY 71T-1
Carbon	0.12 max	0.03
Manganese	1.75 max	1.45
Silicon	0.90 max	0.30
Phosphorus	0.030 max.	0.015
Sulfur	0.030 max.	0.010

BASED ON 100% CO_2

	AWS Spec	Typical
Tensile Strength (psi)	70-95,000	78,000
Yield Strength (psi)	58,000 min.	72,000
Elongation in 2”	22 % min.	28%
Charpy V-notch at 0°F	20 ft·lbs min.	55 ft·lbs

AVAILABLE SIZES: TCF 71T-1= Spools of .035, .045, .052, 1/16, 3/32

SPECIFICATIONS; ANSI/AWS A5.20 E71T-1C, E71T-1M
ASME SFA A5.20 E71T-1C, E71T-1M
(Formerly classified as E71T-1)

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