

Flux Cored Steel

Alloy: WW71T-1
Class: E71T-1

Conforms to Certification: AWS A5.20
ASME SFA A5.20

Alloy: E71T-1
Weld Process: Mig Welding Process

AWS Chemical Composition Requirements

C = 0.18 max	Cr = 0.20 max
Mn = 1.75 max	Ni = 0.50 max
Si = 0.90 max	Mo = 0.30 max
P = 0.03 max	V = 0.08 max
S = 0.03 max	Cu = 0.35 max

Deposited All Weld Metal Properties %

As-Welded

Tensile Strength	90,000psi
Yield Strength	78,500psi
Elongation	27%

Deposited Chemical Composition % (Typical)

C = 0.041	Cr = 0.023
Mn = 1.29	Ni = 0.047
Si = 0.57	Mo = 0.098
P = 0.007	V = 0.02
S = 0.011	Cu = 0.037

Deposited Charpy-V-Notch Impact Properties %

32 ft. lbs. (at 0°F)

Application

E71T-1 is designed for welding mild and medium carbon steels in all positions.

Recommended Welding Parameters

<u>Diameter of Wire</u>	<u>Voltage (V)</u>	<u>Amperage (A)</u>	<u>Shielding Gas</u>
.035 inches	20 – 30	130 – 280	100% Co2 or 75% Argon + 25% Co2
.045 inches	23 – 30	150 - 290	100% Co2 or 75% Argon + 25% Co2

