

Flux Cored Steel

Alloy: WW71T-GS  
Class: E71T-GS

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

Alloy: E71T-GS  
Weld Process: Mig Welding Process

AWS Chemical Composition Requirements

C = 0.30 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

Recommended Operation of Welding Rods

Self Shielding

Diameter	Volts	Amps
.035	23 – 29	130 – 260
.045	24 – 30	150 – 350

Deposited Chemical Composition % (Typical)

C = 0.21	Mn = 0.94	Si = 0.36
P = 0.012	S = 0.007	Al = 1.68
Cr = 0.034	Ni = 0.042	Mo = 0.035
V = 0.004	Cu = 0.043	

Application

E71T-GS is a self-shielding all position flux cored welding wire for single pass applications. The use of DC straight polarity minimizes the risk of burn through. It is excellent on lap and fillet welds on thin mild steels.

Deposited All Weld Metal Properties %

As-Welded

Transverse Tension Test            76,000psi

Deposited Charpy-V-Notch Impact Properties %

Not applicable

