



Changzhou Sanzhong Welding Materials Co.,Ltd

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Standard: AWS E71T-1	Chemical Composition %				
	C	Mn	Si	S	P
Grade E71T-1/E71T-1C	≤ 0.12	≤ 1.75	≤ 0.90	≤ 0.03	≤ 0.03
Type	Spool (MIG)				
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0	Package	S100/1kg S200/5kg S270,S300/15kg-20kg		
X - ray detection requirements: II			Deposited metal diffusible hydrogen (Chromatography or Mercury): ≤10ml/100g		
Mechanical Properties	Yield Strength (Mpa)	Tensile (Mpa)	Elongation (%)	AKV Impact Energy(J) -20℃	
	≥ 390	490 ~ 670	≥ 22	≥ 27	
MIG Welding Current - A	Diameter (MM)	1.0	1.2	1.4	1.6
	Downward welding	80 – 250	120 – 300	140 – 400	180 – 450
	Vertical upward welding		120 – 260	150 – 270	180 – 280
	Vertical down welding		200 – 300	220 – 300	250 – 300
	Horizontal welding		120 – 280	150 – 320	180 – 350
Performance characteristics	E71T-1 is titanium oxide type CO2 gas shielded flux cored wire with excellent welding performance and soft and stable arc.				
	Small splash, easy slag removal, beautiful welding seam. Suitable for welding and welding, can all position of welding, the welding efficiency is high. The weld metal is treated with trace elements , and has good low - temperature toughness , good crack resistance and stable and reliable intrinsic quality .				
Application	The welding of structural parts of carbon steel and low alloy structural steel with tensile strength ≥ 490 MPA is the most widely used in the welding of important structures such as shipbuilding.				
Notice	<ol style="list-style-type: none"> 1. Welding workpiece should be done oil removal, rust removal treatment. 2. During welding , the gas flow is generally between 20 and 25 L / min . 3. When flux-cored wire is welded, the dry elongation should be 15 ~ 25 mm. 4. Welding wire warehouse humidity should be maintained no more than 60%. 5. Non-vacuum packaging wire storage time should not exceed half a year, vacuum packaging wire storage time should not exceed one year. 				



TEL:86 189 1234 9999

E-mail: manager@kkweld.com

Whatsapp : +86 189 1234 9999