ESAB 71T1

ESAB 71T1 is an all position rutile flux cored wire designed for optimum performance with 100% CO2 shielding gas. It produces a slag with good coverage that is easily removable as well as a weld metal that is consistently free of slag inclusions and porosity.

Classifications Weld Metal:	SFA/AWS A5.36:E71T1-C1A0-CS2, EN ISO 17632-A:T 42 0 P C 1 H10
Approvals:	ABS 2Y400, BV 2Y40, DNV IIY40MS, IRS 2Y40SM, LR 2Y

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+
Alloy Type:	C-Mn

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
As Welded	500 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	0 °C	95 J
As Welded	-20 °C	40 J

Typical Weld Metal Analysis %

C	Mn	Si
C1 shielding gas		
0.05	1.10	0.45

Current Range

Diameter	Current	Voltage
1.2 mm	140-300 A	21-32 V
1.6 mm	160-410 A	22-34 V