

Weld 71T-1

FCAW wire for mild steel and 490N/mm² class high tensile steel. Weld 71T-1 is a multi-purpose all position flux cored wire for use with CO₂ or CO₂/Ar mixed gas.

Specifications	
Classifications	SFA/AWS A5.20 : E71T-1C H8 SFA/AWS A5.20 : E71T-1M H8 JIS Z 3313 : T49J0T1-1C/MA-U KS D 7104 : YFW-C502R/A502R EN ISO 17632-A : T46 2 P C 1 H10 EN ISO 17632-A : T46 2 P M 1 H10
Approvals	ABS : 3YSA H10 BV : S3YM H10 CCS : 3YSH10 CE : EN 13479 DNV : III YMS(H10) FBTS : E71T-1C LR : 3YS H10 RS : 3Y40SMH10 RS : 3YSMH10 UKCA : EN 13479

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

Welding Current	DC+
Alloy Type	C Mn
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
C1			
As Welded	495 MPa	560 MPa	31 %
M21			
As Welded	530 MPa	585 MPa	32 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
C1		
As Welded	-20 °C	80 J
As Welded	-30 °C	60 J
M21		
As Welded	-20 °C	110 J
As Welded	-30 °C	85 J

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
C1									
0.05	1.25	0.36	0.006	0.012	0.22	0.02	0.003	0.22	0.01

Typical Weld Metal Analysis %	
Nb	
C1	
0.01	

MILD STEEL

GAS-SHIELDED FLUX-CORED WIRES (FCAW/MCAW)



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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	140-300 A	24-33 V	11.5-15.9 m/min	4.2-5.8 kg/h
1.6 mm	170-410 A	24-36 V	4.8-8.9 m/min	3.1-5.4 kg/h