

Flux-Cored Gas Shielded Continuous Welding Wire

All positions Flux-Cored Gas Shielded Continuous Welding Wire for fabrication of low carbon and low alloy steels. This combines the high deposition rate of flux cored wire with the high efficiencies of solid wire. Providing an exceptionally smooth, stable arc, low spatter and minimal slag coverage. The ZuperMag E71T-1 is used in shipbuilding, machinery, bridges, structural fabrications, automated or robotic welding. Suitable for mild steel or high grade high tensile steels such as pressure vessels, offshore drilling platforms, pipelines, railway wagons, machinery and automobiles etc.

Code & Specification:

ASME / SFA / AWS A5.20, Class E71T-1C

Typical Mechanical Properties:

Yield Strength : 450 MPa
Tensile Strength : 520 MPa
Elongation (L=4D) : 28%
Charpy V-notch Impact : 100 Joules (at - 18°C)

Typical Undiluted Weld Metal Analysis:

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.05	1.3	0.40	<0.02	<0.03

Suggested Welding Parameters (dc+):

Carbon	Flat		Vertical - up		Overhead	
	Volts	Amperages	Volts	Amperages	Volts	Amperages
1.2 mm	23 - 30	150 - 250	22 - 26	150 - 220	23 - 26	150 - 220
1.6 mm	25 - 34	180 - 300	21 - 27	180 - 250	22 - 27	150 - 230

Shielding Gas:

- CO₂ shielding gas with a low dew point (below -40°C) at a flow rate of 20-25 liters per minute is recommended.
- Electrode wire stick out 15-20mm

Packing Size:

15kgs. net weight in plastic spools & drum packing 200kgs. in 1.2mm & 1.6mm size

* **DNV / LRS approvals on specific customer request**



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