



Changzhou Giant Welding Co.,Ltd
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|------------------------------------|--|-------|---------|------------------|-------|--|-------|---------------------------|-------|-----------|-------|
| Standard: AWS A5.20 E71T-8 | Chemical Composition % | | | | | | | | | | |
| | C | Mn | Si | P | Al | S | Cr | Ni | Cu | Mo | V |
| Grade E71T-8 | ≤0.30 | ≤1.75 | ≤0.60 | ≤0.03 | ≤1.80 | ≤0.03 | ≤0.20 | ≤0.50 | ≤0.35 | ≤0.30 | ≤0.08 |
| 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 | 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. | | | | | | | | | | |

