

Technical data sheet

011121MBA

Cored welding wire**ROBOFIL B 71****CLASSIFICATION**

ASME IIC SFA-5.20 / AWS A5.20	E71T-5M-JH4
EN ISO 17632-A	T46 6 B M21 3 H5
EN ISO 17632-B	T55 6 T5-0 M21 A-H5
ASME IX Qualification	QW-432 F-N° 6 QW-442 A-N° 1

DESCRIPTION

- Seamless high fill copper coated basic cored wire for gas shielded metal arc welding
- Single and multipass welding of CMn steels
- Optimal productivity by combining advantages of both seamless and seamed tubular wires
- H_{DM} guaranteed < 4 ml/ 100g deposited metal on the whole parameter box
- No moisture pick up, excellent wire feeding properties
- Excellent mechanical properties

APPLICATIONS

Unalloyed constructional steel, boiler plate, pipe steels, fine-grained steels, shipbuilding steels, cast steels

Examples

Unalloyed construction steels	EN 10025	S185, S235JR to S355K2G4
Boiler plate	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Fine-grained steels	EN 10028-3	P275N, NH, NL1, NL2 to P460N, NH, NL1, NL2
	EN 10113	S275N to S460N, S275M to S460ML
Pipe steels	EN 10208	L240NB to L445NB
	API 5LX	X42, X46, X 52, X60, X65
Pressure vessel plates	ASTM SA-516 Gr55 to SA-516Gr70	
Shipbuilding steels	A, B, D, E, and A32/36 to F40	
Cast steels	DIN 1681	GS-38, GS-45, GS-52

APPROVALS

TÜV (09438.02), DB (42.128.02)

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si
0.06	1.4	0.4

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A₅ [%]	CVN [J]
530	460	22	-60°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	A₅ [%]	CVN [J]
580	480	28	-60°C: 100

SHIELDING GAS

EN ISO 14175: M21 (Ar + 15 - 25% CO₂)

OPERATING CONDITIONS

Diameter [mm]	Current type	Amperage [A]	Voltage [V]	Stick-out [mm]
1.2	DC+ or pulsed	110 - 300	16 - 32	12 - 25
1.6	DC+ or pulsed	160 - 400	20 - 32	15 - 25

WELDING POSITIONS

ROBOFIL B 71 is primarily used in the flat and horizontal-vertical positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.2 mm	1.6 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300	
Weight	15 kg	

Other packaging and other diameters: please consult us

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