

Technical data sheet

011121MBA

Cored welding wire
ROBOFIL R 71+**CLASSIFICATION**

ASME IIC SFA-5.20 / SFA-5.20M:	E71T-1M H4
EN ISO 17632-A:	T 46 4 P M21 1 H5
ASME IX Qualification	QW-432 F-N° 6 QW-442 A-N° 1

DESCRIPTION

- Seamless copper coated wire for flux cored arc welding with a gas shield.
- Rutile, fast freezing slag for all positional welding.
- Excellent welder appeal and wire feeding characteristics.
- Single and multiple pass welding of CMn steels.
- Suitable for welding root runs on ceramic backing.
- No moisture pick up, excellent wire feeding properties.
- Extremely low hydrogen content.
- For use with mixed gas.

APPLICATIONS

Unalloyed or low-alloy construction steels, boiler plates, pipe steels, fine-grained steels and shipbuilding steels.

Examples

Unalloyed construction steels	EN 10025	S235JRG1 to S355J2G3
Boiler plate	EN 10028-2	P235GH to P355GH
Fine-grained steels	EN 10113	S275 to S420N, P275NL to P420NL
Pipe steels	EN 10208	L240NB to L415NB
	API 5LX	X42, X46, X52, X60
Shipbuilding steels	A, E, A32 - F40	
	ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1	

APPROVALS

DB (42.128.04), LR, TÜV (11362.06)

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si
0.04	1.2	0.4

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
550	460	20	-40°C: 47

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp0.2% [MPa]	As [%]	CVN [J]
570	510	25	-40°C: 70

SHIELDING GAS

ISO 14175: M21 (Ar + 15 - 25% CO₂)

OPERATING CONDITIONS

Diameter [mm]	Stick-out [mm]	Current type	Current [A]	Voltage [V]
1.2	15 ± 5	DC+	100 - 300	22 - 32
1.6	15 ± 5		200 - 400	22 - 32

WELDING POSITIONS

EN ISO 6947 & ASME IX: all positions.

PACKAGING

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

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.