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| Technical data sheet <small>011121MBA</small> | Cored welding wire WA TUB CS 71 |  Welding Alloys |
|---|--|---|

CLASSIFICATION

| | |
|---------------------------------|------------------------------|
| ASME IIC SFA 5.20 / AWS A 5.20: | E71T-1 |
| EN ISO 17632-A: | T 42 2 P C 1 H5 |
| ASME IX Qualification | QW432 F-N° 6 QW442 A-N° 1 |

DESCRIPTION

- Gas shielded flux cored wire for general use applications
- Rutile, fast freezing slag for all positional welding
- Excellent welder appeal with low spatter level
- Single and multiple pass
- For use with CO₂ or 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 |
| Shipbuilding steels | A, E, A32 - F40 | |
| | ISO/TR 15608: Groups 1.1, 1.2, 1.3, 2.1 and 3.1 | |

TYPICAL ALL-WELD METAL ANALYSIS [wt.%] – [CO₂ shielding gas]

| | | |
|----------|-----------|-----------|
| C | Mn | Si |
| 0.06 | 1.5 | 0.5 |

MINIMUM ALL-WELD METAL MECHANICAL PROPERTIES – [CO₂ shielding gas]

| | | | |
|-----------------|---------------------|---------------|----------------|
| Rm [MPa] | Rp0.2% [MPa] | As [%] | CVN [J] |
| 550 | 410 | 22 | -20°C: 47 |

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES – [CO₂ shielding gas]

| | | | |
|-----------------|---------------------|---------------|----------------|
| Rm [MPa] | Rp0.2% [MPa] | As [%] | CVN [J] |
| 600 | 510 | 28 | -20°C: 100 |

SHIELDING GAS

C1 (CO₂) or M21 (Ar + 15 - 25% CO₂) according to EN ISO 14175

OPERATING CONDITIONS

| Diameter [mm] | Stick-out [mm] | Current type | Current [A] | Voltage [V] |
|---------------|----------------|--------------|-------------|-------------|
| 1.2 | 15 ± 5 | DC+ | 140 - 340 | 24 - 36 |
| 1.6 | 15 ± 5 | | 200 - 420 | 26 - 42 |

WELDING POSITIONS

All positions

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