

Technical data sheet

EN260625GB

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

| | |
|-------------------------------|-----------------------------|
| ASME IIC SFA-5.20 / AWS A5.20 | E70T-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

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.