

# ESAB 71T1

ESAB 71T1 is an all position rutile flux cored wire designed for optimum performance with 100% CO<sub>2</sub> shielding gas. It produces a slag with good coverage that is easily removable as well as a weld metal that is consistently free of slag inclusions and porosity.

<b>Classifications Weld Metal</b>	SFA/AWS A5.20 : E71T-1C EN ISO 17632-A : T 42 0 P C 1 H10
<b>Approvals</b>	ABS 2Y400 BV 2Y40 IRS 2Y40SM LR 2Y

Approvals are based on factory location. Please contact ESAB for more information.

<b>Welding Current</b>	DC+
<b>Alloy Type</b>	C-Mn

## Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
<b>C1 shielding gas</b>			
As Welded	500 MPa	550 MPa	28 %

## Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
<b>C1 shielding gas</b>		
As Welded	0 °C	95 J
As Welded	-20 °C	40 J

## Typical Weld Metal Analysis %

C	Mn	Si
0.05	1.10	0.45

## Current Range

Diameter	Current	Voltage
1.6 mm	160-410 A	22-34 V
1.2 mm	140-300 A	21-32 V