

Flux Cored Welding Wire for Welding of Un-Alloy Steels

Classification

AWS A5.20 : E71T-1H8
EN ISO 17632-A : T42 2 PC 2 H10

General Description

All position gas shielded flux cored wire for high quality welding.
Excellent operator appeal due to superior welding characteristics.
Specially developed for welding with 100% CO₂. Also suitable for welding on coated plate with use of 100% CO₂.
Smooth arc with low spatter.
Good mechanical properties.
Excellent wire feeding.

Chemical Composition (w%), Typical, All Weld Metal

C	Si	Mn	P	S
0.05	0.50	1.50	< 0.015	< 0.015

Mechanical Properties, Typical, All Weld Metal

Yield Strength : 525 N/mm²
Tensile Strength : 597 N/mm²
Elongation (L=5d) : 28 %
Impact ISO-V : 106 J (-20°C)

Approvals

ABS	RINA	SEPRO
E71T-1H8	3Y S H10	+

Shielding Gases (acc. ISO 14175 and EN 439)

Amount

Current Type

MAG : C1 - CO ₂ (%100)	15 - 25 l/min	DC(+)
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Packaging and Available Sizes

Diameter	0.8	1.0	1.2	1.6	2.0	2.4	2.8	Spool Weight
Flux Cored Wire	-	-	X	-	-	-	-	15 kg



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Materials to be Welded

General Structural Steel	: S185, S235, S275
Ship Plates	: Grade A, B, D, AH32 - EH36
Cast Steel	: GP240R
Pipe Material	: X42, X46, X52
Boiler & Pressure Vessel Steel	: P235GH, P265GH, P295GH, P355GH P275N/NH, P355N/NH
Fine Grained Steel	: S275, S355, S420 S275M, S275ML, S355M, S355ML, S420M, S420ML