



Changzhou Sanzhong Welding Materials Co.,Ltd

www.asweld.com

Standard: AWS E71T-GS	Chemical Composition %						
		C	Mn	Si	S	P	Al
Grade E71T-GS	Sample1	0.26	0.91	0.50	0.014	0.016	2.05
	Sample2	0.22	1.00	0.24	0.005	0.015	2.02
Type	Spool (MIG)						
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0		Package	S100/1kg S200/5kg S270/15kg			
X - ray detection requirements: II			Deposited metal diffusible hydrogen (Chromatography or Mercury): -				
Mechanical Properties	Yield Strength (Mpa)		Tensile Strength (Mpa)		Elongation(%)		AKV Impact Energy(J) -20℃
	- - -		≥ 490		- - -		- - -
MIG Welding	Diameter (MM)		1.0	1.2	1.4	1.6	
	F		80 - 200	160 - 220	170 - 250	180 - 280	
Current - A	V - up / OH		55 - 120	120 - 180	140 - 200	160 - 220	
Performance characteristics	<p>E71T-GS is a self-shielded flux-cored wire, with good arc stability, vertical direction and good shape of welding pipe.</p> <p>Perfect welding joint can also be obtained when the wind speed is about 10M/S.</p>						
Application	Light weight steel frame, Suitable for low impact value, plate thickness 1.0-4.5 mm welding.						
Notice	<ol style="list-style-type: none"> 1. Welding workpiece should be done oil removal, rust removal treatment. 2. Welding current should be used DCP; note-it is only necessary to change the polarity of the voltage detection line due to the variable-voltage source. 3. When flux-cored wire is welded, the dry elongation should be 10 ~ 20 mm. 4. Welding wire warehouse humidity should be maintained no more than 60%. 5. Non-vacuum packaging wire storage time should not exceed half a year, vacuum packaging wire storage time should not exceed one year. 						



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