

FLUX CORED WIRE: CARBON STEEL

# **SARTHAK E71T1**

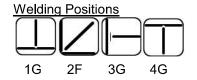
AWS-A/SFA5.20E71T-1C

## **Applications**

SARTHAK E71T1 is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-36 /SA-36M and A,B,C,D grades of SA-283 / SA-283M & SA-414 / SA-414M.(P.No.1) e.g. Fabrication in chemical plant machinery structures & Steel frames in ship building, heavy bridges & towers.

### Characteristics on Usage

SARTHAK E71T1 is an all position Rutile flux cored wire designed for optimum performance when using CO2 shielding. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce fewer fumes, minimal spatter.



Recommended Stick Out

Shielding Gas Carbon Dioxide (CO2) shielding 15 - 20mm

Chemical Composition Of Weld Metal

Element	С%	Mn%	Si%	S%	P%
Typical Values	0.05	1.25	0.38	0.010	0.018
Spec.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max

Reqd.

# Mechanical Properties Of Weld Metal

Property	U.T.S.	Y.S.	ELONGATION	CVN IMPACT	
	$(N/mm^2)$	(N/mm²)	( L = 4d ) %	AT - 20°C ( J )	
Typical Values	550	470	26	60	
Spec. Reqd.	490-670	390 Min	22 Min	27 Min	

## Welding Parameters (DC + VE)

Diameter	Flat		Vertical - Up		Overhead	
(mm)	(A)	(V)	(A)	(V)	(A)	(V)
1.20	180-210	26-30	150-210	22-26	180-210	26-30
1.60	210-250	26-30	180-250	21-27	210-250	26-30

### **Packing**

15 kgs. vaccum packed plastic spool.

