

FLUX CORED WIRE : CARBON STEEL

SARTHAK E71T5

AWS-A/SFA5.20E71T-5C

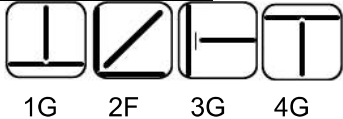
Applications

SARTHAK E71T5 is designed for all position single and multipass welding of low and medium carbon steels. Suitable for joining steels conforming to ASTM SA-525-70, and C grades of SA-285, IS: 2002-2A & 2B IS2062, IS226 & DIN 17155 HIV e.g. Construction of bridges, Pressure vessel & Offshore structures.

Characteristics on Usage

SARTHAK E71T5 is an all position basic type flux cored wire - having stable and smooth arc with good slag detachability using CO₂ shield. The slag coverage is complete and easy to remove. Weld metal is consistently free of inclusions and porosity for radiography soundness. This wire is formulated to have high resistance to cracking with fewer fumes & minimal spatter.

Welding Positions



Recommended Stick Out

15-20 mm

Shielding Gas

Carbon Dioxide (CO₂) shielding

Chemical Composition Of Weld Metal

Element	C%	Mn%	Si%	S%	P%	Ni %
Typical Values	0.050	1.25	0.45	0.010	0.018	0.40
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max	0.50 Max

Mechanical Properties Of Weld Metal

Property	U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	IMPACT (CVN) AT - 30° C (J)
Typical Values	550	470	26	60
Spec. Reqd.	490-670	390 Min	22 Min	27 Min

Welding Parameters (DC + VE)

Diameter (mm)	Flat		Vertical - Up		Overhead	
	(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.