



## 71T-GS

### Classification

AWS A5.20/A5.20M(2012) : E71T-GS

EN ISO 17632 A(2008) : T42 Z Y N 1

EN ISO 17632 B(2008) : T49 Z T11-1NA

### Approvals

ABS : E71T-GS (AWS A5.20)

CWB : CWS W48 E491T14S-AZ-CS3 (E491T-GS)

### Features

- Fast freezing slag system
- Good bead appearance & slag removal
- Stable & smooth arc, low spatter level

### Applications

- Sheet or thin gauge metal
- Suitable for all mild steel structures, pressure vessels, boilers, wagons, tanks, ships etc.
- Manufacturing - Architectural and Structural Metals, Mining, Agricultural, Motor Vehicles, Aerospace, Shipbuilding
- General Fabrication & Construction - Residential, Commercial, Bridges, Dams, Utilities
- Or any other industry where welders may work

### Diameters & Packages

Diameter	2 Lbs.	10 Lbs.	33 Lbs.
.030"	✓	✓	✓
.035"	✓	✓	✓
.045"	✓	✓	✓
.062"	✓	✓	✓

### Technical Specifications

**Storage:** Product should be stored in a dry, enclosed environment, and in its original intact packaging

#### Polarity & Shielding gas:

- No Gas (Self-shielded)    • DCEP (DC-)

#### Typical Chemical Composition Of All-Weld Metal Deposit (Chem Pad)

Shielding Gas	C(wt%)	Si(wt%)	Mn(wt%)	P(wt%)	S(wt%)	Al(wt%)
AWS Spec.	Not Required					
Typical	0.10	0.10	0.55	0.015	0.006	1.25

Note: AWS specification's single values are maximums

#### Typical mechanical properties of all-weld metal (As Welded)

	Yield Strength Mpa(ksi)	Tensile Strength Mpa(ksi)	Elongation (%)
AWS A5.20		Min. 490	
EN ISO 17632-B	min. 390	490~670	min. 18
Typical	500 (73)	530 (77)	23

#### Product Dimensions and Weld Current Range

Welding Position	Sizes (in)	Amper (A)		Volt (HV)	
		Min.	Max.	Min.	Max.
F, HF	.030"	80	120	16	20
VU	.030"	100	160	15	18
F, HF	.035"	80	120	16	20
VU	.035"	100	160	15	18
F, HF	.045"	140	200	17	20
VU	.045"	120	160	16	18
F, HF	.062"	180	260	19	22
VU	.062"	160	220	17	20

