DURAMAX™
Inspiring the future generations of welders

# PRODUCT DATA SHEET

## Flux Cored Wire

Weld Process: Mig Welding Process
Alloy: Mild Steel  Class: E71TGS
Conforms to Certification:  AWS A5.20 / ASME SFA 5.20

## Alloy: DM71TGS

**TYPICAL APPLICATION:**

**Dura Max E71TGS** is a self-shielded flux cored wire for lap and fillet welds of mild and medium tensile steels not exceeding 510MPa. It is suitable for a variety of applications such as prefab, building fabrication, tanks, ornamental iron, farm implement, repairs and general fabrication.

**CHARACTERISTICS ON USAGE:**

1- Wire is for all-positional welding of single pass automatic and semiautomatic fabrications.
2- It can be applicable for aluminized steel and galvanized steel from 1.2 to 5.0mm.
3- It is designed for on-site general fabrication and structural work requiring no impact properties.
4- It can be used DCEN polarity.

**Typical Chemical Composition of all-weld metal (%)**

| C | Mn | Si | P | S | Cr | Ni | Mo | Al | Cu |
|---|---|---|---|---|---|---|---|---|---|
| 0.10 – 0.30 | 0.40 – 0.90 | 0.20 - 0.50 | ≤ 0.20 | ≤ 0.020 | ≤ 0.10 | ≤ 0.10 | ≤ 0.10 | 1.20 – 1.70 | ≤ 0.10 |

**All Weld Metal Mechanical properties (Typical)**

| | YS (Mpa) | UTS (Mpa) | EL % |
|---|---|---|---|
| **AWS** | 390 Min | 490 Min | 22 Min |
| **Typical Values** | 460 | 540 | 25 |

**Sizes available and recommended currents (DC wire -)**

| Diameter | 0.030 | 0.035 | 0.045 |
|---|---|---|---|
| Polarity | DC - | DC - | DC - |
| Shielding Gas Used | ------ | ------ | ------ |
| Wire Feed (in/min) | 200 | 160 | 110 |
| Voltage (V) | 15 | 17 | 18 |
| Current (A) | 100 | 115 | 160 |
| Preheat Temp °C (F) | 150 (300) | 150 (300) | 150 (300) |