

Flux Cored Wire

Weld Process: Mig Welding Process

Alloy: Mild Steel Class: E71T-XX

Conforms to Certification: AWS A5.20 / ASME SFA 5.20

Alloy: DM71T

TYPICAL APPLICATION:

Dura Max E71T-1 is designed for welding of 490MPa high tensile steel with slow freezing slag system. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.

CHARACTERISTICS ON USAGE:

- 1- Wire is a titania type of flux cored wire for all-position welding.
- 2- It features excellent mechanical properties, easy slag removal, low spatter loss
- 3- DM71T-1 has very efficient welding due to higher deposition rate particularly.
- 4- The shielding gas should be used 100%CO₂ or 75% Ar+25%CO₂ for welding

Typical Chemical Composition of all-weld metal (%)

C	Mn	Si	P	S	Cr	Ni	Mo	V	Cu
0.18	1.75	0.90	0.03	0.03	0.02	0.50	0.30	0.08	0.35
max	max	max	max	max	max	max	max	max	max

All Weld Metal Mechanical properties (Typical)

	YS (Mpa)	UTS (Mpa)	EL %	CHARPY "V" NOTCH IMPACT (J) @ -20°C
AWS	≥ 390	≥ 490	≥ 22	≥ 27
Typical Values	520	580	29	50 (J)

Note Diffusible Hydrogen: < 10.0ml/100gr or < 8.0ml/100gr

Sizes available and recommended currents (DC wire +)

Diameter	0.035	0.045	0.052	1/16
Polarity	DC +	DC +	DC +	DC +
Shielding Gas Used	75% Ar+25%CO ₂	75% Ar+25%CO ₂	75% Ar+25%CO ₂	75% Ar+25%CO ₂
Voltage (V)	20	24	24	25
Wire Feed Speed (in/min)	160	300	300	250
Current (A)	120	200	210	210
Preheat Temp °C (F)	20 (70)	20 (70)	20 (70)	20 (70)
Interpass Temp °C (F)	150 (300)	150 (300)	150 (300)	150 (300)