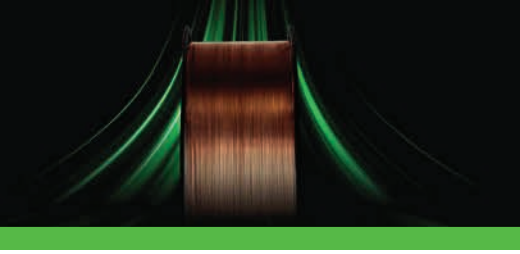
BT WELD



BT WELD 71T-1M FLUX CORED MIG WIRE

KEY FACTS

- Premium general purpose E71T-1 flux cored wire
- Designed for Argon/CO2 gas mixes for lower operating cost
- Excellent weldability with low spatter and a smooth arc characteristics
- Low Hydrogen content with good slag detachability
- Vacuum sealed for long life

DESCRIPTION

A premium, precision layer wound, flux cored mild steel MIG wire for use with CO2 shielding gas. Titanium Oxide slag system with excellent weld-ability, bead appearance, mechanical properties, high impacts and low diffusible hydrogen content.

Recommended for single or multipass welding of low carbon and low alloy high strength steel with 500Mpa grade. Approved for all welding positions including vertical down.

CLASSIFICATIONS

AWS A5.36 E71T1-M21A2-CS1-H8

EN ISO17632-A:T42 2 Z R C1 1 H8

APPROVALS

CE, TUV, ABS, BV, CCS, GL, DNV, KR, LR, NK, RS for 3YSH5

RECOMMENDED SHIELDING GAS

75-25% Argon/ CO2 gas mixes

WELDING POSITIONS

All positional, including vertical-down



PA PB PC PD PE PF PG

APPLICATIONS

Most suitable in production or general fabrication where highest deposition rates and low spatter is required including farm machinery, construction equipment and carbon steel fabrication.

- Structural or general steel fabrication
- Construction of rural equipment
- Pressure vessels
- Earth moving equipment
- Construction of ships & storage vessels
- Machinery and piping

TYPICAL WIRE ANALYSIS

C Carbon	Mn Manganese	Si Silicon	Cr Chromium	Ni Nickel
< 0.12	< 1.75	< 0.90	< 0.20	< 0.50
Mo Molybdenum	**S Sulphur**	**P Phosphorus**	**Cu Copper**	**V Vanadium**
< 0.30	< 0.03	< 0.03	< 0.35	< 0.08

TYPICAL WELD MECHANICAL PROPERTIES

Yield Strength	> 400 MPa
Tensile Strength	490 – 660 MPa
Elongation	> 22%
Impact Strength	27 J @ -20°C

PACKAGING & ORDERING INFORMATION

Size	Packet	Part Number
1.2mm	15kg	200255
1.6mm	15kg	200256
Pallets are 1080kg (72 D300 spools)		

Disclaimer: The above information is provided as a guide; actual welding current and voltage will depend on the welding machine characteristics, which will vary fro model to model. Other variables include run length and size, plate thickness, operator technique and gas type (if used). The user must evaluate the process, application and recommended professional advice. Under no circumstance will Dynaweld or its affiliates be liable for misuse or application of products; this is entirely up to the user's ability.