

Strongweld Dual Shield Tubular Wire 71M

Mild Steel Tubular Wire for Flux Core Arc Welding (FCAW) with gas protection.

Classification

EN ISO 17632-A
T46 2 P C/M 1 H10

AWS A5.20
E71T-1C/1M H8

*Meets with AWS D1.8 & FEMA 353

Description

- Strongweld 71M (aka Indura 71V) is a mild steel, gas-shielded flux-cored wire designed to provide high deposition rates and flat bead appearance required in many out-of-position applications. It features premium arc performance and fast freezing slag.
- High Deposition Rates - Increase weld deposition to more than 10 lbs/hr. out-of-position. Flat Bead Appearance. Fast freezing slag for a flat bead shape and increased productivity in all positions including vertical up.
- Wide Operating Range - Operators can set the machine on a single setting and weld in all positions.
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.
- Shielding gas, CO2 100% and Mix Ar+20% CO2 (32 – 53 cfh).

Typical Chemical Composition of All-Weld Metal (%):

C	Mn	Si	P	S
0.03	1.44	0.59	0.013	0.010

Typical Mechanical Properties of All-Weld Metal:

	Yield Strength, Ksi	Tensile Strength, Ksi	Elongation (L=4d), %	Impact Test Charpy-V
AWS A5.20	Min. 58	70 - 95	22	20 ft*lbf at 0°F
Strongweld 71M	79	88	30	48 ft*lbf at 0°F

Approvals:

Shielding gas	ABS	BV
Mix	2YSA, H10	-
Co2	2YSA, H10	SA2YHH

Packaging, sizes and code SAP:

Diameter	0.035"/0.9mm	0.045"/1.1mm		1/16"/1.6mm	
Packaging	33Lb	33Lb	44Lb	33Lb	44Lb
Code SAP	1038611	1036764	1036767	1034061	1036768

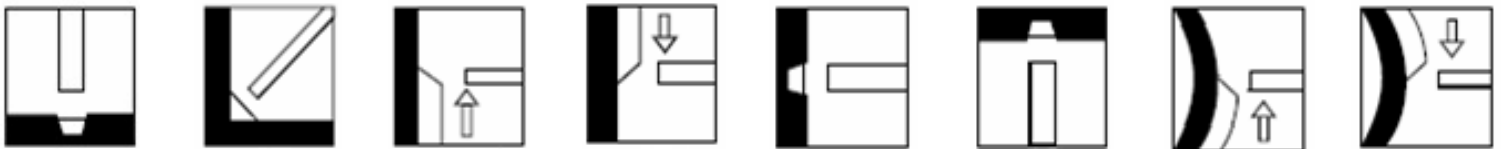
Calculation Data:

Diameter	Stick- Out (Pulg)	Wire Feed Speed (Pulg/min)	Current (A)	Arc Voltage (v)	Deposition Rate (lb/h)
0.045"	5/8	177	130	21-23	3
		322	190	25-28	6
		598	280	30-32	11

Recommender Operating Parameters:

Diameter, Inch	0.035"/0.9mm		0.045"/1.1mm		1/16"/1.6mm	
Type Parameter	Current (amp)	Voltage, Volts	Current (amp)	Voltage, Volts	Current (amp)	Voltage, Volts
Flat (1G/2F)	100 - 240	20 - 28	180 - 280	25 - 31	200 - 380	24 - 32
Horizontal (2G)	120 - 220	20 - 26	180 - 240	25 - 30	200 - 280	25 - 30
Horizontal (2F)	120 - 260	20 - 28	180 - 300	25 - 32	200 - 380	24 - 32
Vertical (3G/3F ↑)	80 - 220	21 - 26	160 - 240	26 - 30	180 - 260	25 - 31
Overhead (4G↑)	80 - 220	20 - 26	160 - 240	25 - 28	200 - 240	25 - 30
Pipe (5G↑ / 6G)	100 - 260	20 - 28	180 - 240	26 - 30	200 - 250	26 - 31
ESO, Inch	1/2 to 1"		1/2 to 1"		1/2 to 1"	

Welding Positions



DCEP – DC+