

## FEATURES

- Oxide-free wire surface promotes clean, shiny weld beads and good feeding characteristics
- Intended for welding single and multiple pass fillets and grooves in all positions
- Can be used with both 100% CO<sub>2</sub> and 75-80% Ar/balance CO<sub>2</sub> shielding gases
- Arc transfer is a small droplet spray transfer in both shielding modes
- Ideal for welding carbon steels in structural steel and general fabrication applications
- Typical applications are shipbuilding, railcar fabrication, and earthmoving machinery

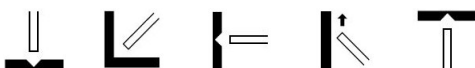
## CONFORMANCES

<b>AWS A5.20</b>	E71T-1C
	E71T-1M
	E71T-9C
	E71T-9M
<b>ASME SFA 5.20</b>	E71T-1C
	E71T-1M
	E71T-9C
	E71T-9M
<b>AWS A5.36</b>	E71T1-C1A2-CS2
	E71T1-M21A2-CS2

## DIAMETERS (in [mm])

0.045 (1.2), 0.052 (1.3), 1/16 (1.6)

## POSITIONS



## SHIELDING GAS

Ar + 20-25% CO<sub>2</sub>, 100% CO<sub>2</sub>  
Flow Rate: 40 - 50 CFH

## POLARITY

Direct Current Electrode Positive (DCEP)

## TYPICAL WELD DEPOSIT CHEMISTRY [WT%]

Shielding Gas	C	Cr	Cu	Mn	Mo	Ni	P	S	Si	V
100%CO <sub>2</sub>	0.05	0.03	0.04	1.20	0.01	0.02	0.010	0.010	0.35	0.02
75%Ar / 25%CO <sub>2</sub>	0.05	0.03	0.04	1.45	0.01	0.03	0.010	0.010	0.45	0.02

## TYPICAL MECHANICAL PROPERTIES

Shielding Gas	Tensile Strength ksi (MPa)	Yield Strength ksi (MPa)	Elongation (%)	Weld Condition	PWHT Temp	CVN @ -20°F (-30°C) ft-lb (J)	CVN @ -40°F (-40°C) ft-lb (J)
100%CO <sub>2</sub>	79 (545)	68 (469)	29	As-Welded	-	40 (54)	30 (41)
75%Ar / 25%CO <sub>2</sub>	87 (600)	77 (531)	28	As-Welded	-	45 (61)	32 (43)



Notice: Be sure to follow all your employers safety practices, policies and procedures when using this product. Refer to CSA W117.2 and ANSI Z49.1 Safety in Welding, Cutting and Allied Processes for further information and the manufactures SDS sheet. The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.

## RECOMMENDED WELDING PARAMETERS \*\*

Diameter in (mm)	Shielding Gas	Position	WFS* in/min (m/min)	Amps	Volts	CTWD* in (mm)
0.045 (1.2 mm)	75% Ar/25% CO2	All Positions	240 (6.1)	165	23	1/2 (13)
		Flat & Horizontal	265 (6.7)	180	24	1/2 (13)
		All Positions	310 (7.9)	190	25	5/8 (16)
		All Positions	410 (10.4)	225	27	1 (25)
		Flat & Horizontal	410 (10.4)	225	26	5/8 (16)
		Flat & Horizontal	550 (14.0)	265	31	1 (25)
0.052 (1.3 mm)	75% Ar/25% CO2	All Positions	150 (3.8)	160	23	5/8 (16)
		Flat & Horizontal	190 (4.8)	200	23	5/8 (16)
		All Positions	230 (5.8)	210	25	3/4 (19)
		All Positions	340 (8.6)	260	26	1 (25)
		Flat & Horizontal	360 (9.1)	280	26	3/4 (19)
		Flat & Horizontal	475 (12.1)	340	31	1 (25)
1/16 (1.6 mm)	75% Ar/25% CO2	All Positions	135 (3.4)	185	23	3/4 (19)
		All Positions	175 (4.4)	220	25	1 (25)
		Flat & Horizontal	170 (4.3)	220	23	5/8 (16)
		All Positions	240 (6.1)	275	26	1 (25)
		Flat & Horizontal	295 (7.5)	320	27	3/4 (19)
		Flat & Horizontal	420 (10.7)	380	31	1 (25)

\* WFS = Wire Feed Speed, CTWD = Contact Tip To Work Distance

\*\*The parameters listed are recommended starting points of operation and the ranges for amperage, wfs, and voltage could be extended based on fitness for application. For products with "all-position" capability, as determined and listed in classification, the position recommendation can be determined based on operator skill and material thickness and isn't limited to the listing.

For 100% CO2 shielding gas, raise the voltage by 1 to 1.5 volts.

## PACKAGING (lbs (kgs))

33 (15) Spools, 60 (27.2) Coils, 500 (226.8) Round Drum, 800 (362.9) Hex Drum, 900 (408.2) Hex Drum

\*Some packaging options may not be available depending on diameter and product. Special package options may be available upon request.

## STORAGE AND HANDLING

All products should be stored in original packaging, in dry conditions and handled with care. For more information refer to our website.



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