

Data Sheet

Flux cored wire

Materials Services
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Designation

TI E71T-1M H10

Name

E71T-1M

Material No.

Approvals

EN ISO 17632-A: T46 3 P M21 1 H10

AWS A 5.20: E71T-1M

JIS Z 3313 T 49J 0 T1-1 M A-U



Characteristics and Applications:

TI E71T-1M H10 is a flux cored wire designed to be used with Ar/CO² gas. It is available for all positions welding with both single and multiple pass welds on mild and 490 N/mm² high tensile steels. It features good impact properties, less fume, stable arc, easy slag removable and excellent X-Ray inspection. Typical applications include shipbuilding, storage vessels, structural fabrication, machinery and piping etc.

Typical chemical composition of weld metal (wt%):

C	Mn	Si	P	S
0.04	1.30	0.30	0.013	0.007

Typical mechanical properties of weld metal:

Yield strength MPa (Ksi)	Tensile strength MPa (ksi)	Elongation (%)	Charpy V-Notch J (ft-lbf) -30 (-20°F)
567 (82)	608 (88)	29	66 (49)

Sizes and recommended current range (DC <+>):

Stick out: 15-25 (mm), flow rate: 20-25 (l/min)

Parameters \ Diameter (mm)	1.2
F	140A~300A / 22V-36V
HF	140A~300A / 22V-36V
H	140A~280A / 22V-33V
VU, OH	140A~220A / 22V-28V
VD	230A~280A / 28V-33V

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