

Standard: AWS E71T-GS	Chemical Composition %						
		C	Mn	Si	S	P	Al
Grade E71T-GS	Sample1	0.26	0.91	0.50	0.014	0.016	2.05
	Sample2	0.22	1.00	0.24	0.005	0.015	2.02
Type	Spool (MIG)						
Specification (MM)	0.8、0.9、1.0、1.2、1.6、2.0		Package		S100/1kg	S200/5kg	S270/15kg
X - ray detection requirements: II			Deposited metal diffusible hydrogen (Chromatography or Mercury): -				
Mechanical Properties	Yield Strength (Mpa)	Tensile Strength (Mpa)		Elongation(%)	AKV Impact Energy(J) -20℃		
	- - -	≥ 490		- - -	- - -		
MIG Welding	Diameter (MM)	1.0	1.2	1.4	1.6		
	F	80 - 200	160 - 220	170 - 250	180 - 280		
Current - A	V - up / OH	55 - 120	120 - 180	140 - 200	160 - 220		
Performance characteristics	<p>E71T-GS is a self-shielded flux-cored wire, with good arc stability, vertical direction and good shape of welding pipe.</p> <p>Perfect welding joint can also be obtained when the wind speed is about 10M/S.</p>						
Application	Light weight steel frame, Suitable for low impact value, plate thickness 1.0-4.5 mm welding.						
Notice	<ol style="list-style-type: none"> <li>1. Welding workpiece should be done oil removal, rust removal treatment.</li> <li>2. Welding current should be used DCP; note-it is only necessary to change the polarity of the voltage detection line due to the variable-voltage source.</li> <li>3. When flux-cored wire is welded, the dry elongation should be 10 ~ 20 mm.</li> <li>4. Welding wire warehouse humidity should be maintained no more than 60%.</li> <li>5. Non-vacuum packaging wire storage time should not exceed half a year, vacuum packaging wire storage time should not exceed one year.</li> </ol>						