



FOR CARBON STEEL
PRODUCT (GMAW)
ET71T-1

FEATURES

- *ALL POSITION WELDING
- *quick freeze and stable arc
- *GOOD BEAD APPEARANCE AND LOW SPATTER
- *high deposition efficiency

APPLICATION

STRUCTURAL FABRICATION, shipbuilding, general fabrication, pressure vessels

CLASSIFICATION

*A5.20/ ASME SFA5.20 ET71T-1

CHEMICAL COMPOSITIONS

C	Si	Mn	P	S	CR	Ni	MO
0.05	0.48	1.28	0.009	0.009			

MECHANICAL PROPERTIES

Y.S	T.S	EL	Temp.	CVN-Impact Value
N/mm2 (lbs/in 2)	N/mm2 (lbs/in 2)	(%)	oC (oF)	J (ft lbs)
548 (79,600)	582 (84,500)	28.0	-20 (-4)	45(33)

WELDING PARAMETERS

DIAMETER (mm)		1.2
SPOOL (KGS)		15
CURRENT (amps)		

CURRENT

DC +

GAS

100% CO2

WELDING POSITIONS

Current



= + ~ (Uo: 50 V)

ASME:	1G	2F	2G	3G	3G	4G	5G
ISO 6947	PA	PB	PC	PF	PG	PE	PF/PG
