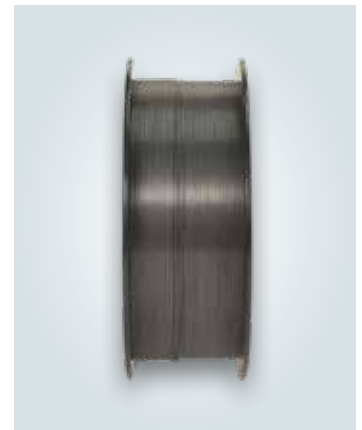




ADVANTAGE™ E71T-1M Flux-Cored Wire



ADVANTAGE™ 71T-1M is a flux-cored wire formulated for use with argon/CO₂ blends and designed for all position welding of carbon steel. It is level wound and features excellent feedability, a soft arc, low spatter and reduced fume generation when compared to 100% CO₂.

Features and Benefits

- High deposition
- Outstanding mechanical properties
- Excellent feedability
- Soft welding arc
- Less spatter
- Smooth bead shape
- Lower welding fume when compared to 100% CO₂
- All position welding

Classification

- AWS A5.20/A5.20M:2005
- E71T-1C/1M-H8
- E491T-1-H8
- E491T-1-1M-H8

Shielding gas

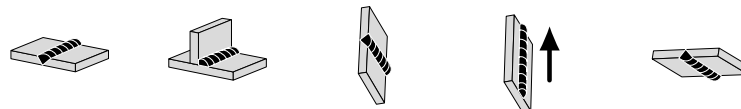
- STARGOLD™ C5 gas blend
- STARGOLD C10 gas blend
- STARGOLD C15 gas blend
- STARGOLD C20 gas blend
- STARGOLD C25 gas blend
- 100% CO₂

Applications

For all position welding of 70,000 psi (490 Mpa) carbon steel applications including:

- Machinery
- Shipbuilding
- Offshore Construction
- Bridges
- Trailers
- General Fabrication

Welding Positions



Welding Conditions for Mechanical Property Test

Electrode	.045" (1.2 mm)
Wire feed speed (in/min)	300 IPM
Polarity	DC+
Current (A)	200 A
Shielding gas used	75% Ar + 25% CO ₂
Preheat temp. °F (°C)	70 (20)
Voltage (V)	24V
Interpass temp. °F (°C)	300 (150)

Typical Chemical Analysis (As Welded)

Weld metal analysis	Typical 75% Argon/25% CO ₂	100% CO ₂	AWS A5.20
Carbon	0.05	0.04	0.12 Max
Silicon	0.58	0.45	0.90 Max
Manganese	1.52	1.24	1.75 Max
Phosphorous	0.011	0.013	0.03 Max
Sulfur	0.006	0.006	0.03 Max
Chromium	0.04	0.04	0.20 Max
Nickel	0.05	0.05	0.50 Max
Molybdenum	0.005	0.005	0.30 Max
Copper	0.02	0.02	0.35 Max

Mechanical Properties (As Welded)

Mechanical tests	Typical 75% Argon/25% CO ₂	AWS A5.20
Tensile strength	87 ksi (595 Mpa)	70-96 ksi (490-670 Mpa Min)
Yield strength	76 ksi (525 Mpa)	58 ksi (390 Mpa Min)
Elongation	27%	22% Min

Typical Charpy V-Notch Impact Test Results (As Welded)

CVN temperatures	Typical	ADVANTAGE™ 71M
Avg. at 0°F (-20°C)	33.2 ft-lbs (45 Joules)	20 ft-lbs (27 Joules Min)

Recommended Parameters for Standard Diameters

Wire type	.045 in. (1.2 mm)	.052 in. (1.4 mm)	.062 in. (1.6 mm)
Flat (PA/1G)	120/300A, 27/30V	80/320A, 24/30V	180/400A, 27/33V
Horizontal (PC2G)	140/260A, 27/30V	150/240A, 21/30V	200/360A, 26/31V
Vertical (PF3G)	160/240A, 25/31V	170/310A, 26/30V	180/260A, 27/30V

Linde has a detailed parameter chart available for this product.

Commonly Ordered Part Numbers

Wire type	Diameter (in.)	Packaging	Part number
E71T-1M	0.045	44 lb Spool	ADG71T1M04544
E71T-1M	0.052	44 lb Spool	ADG71T1M05244
E71T-1M	0.062	44 lb Spool	ADG71T1M11644

- Storage** → Store in a dry, enclosed environment
→ Store in its original, intact packaging

ADVANTAGE™ flux-cored welding wire is well protected against moisture – is paper lined and wrapped in plastic, with silica gel.



Step 1
Opening the rugged, glued box



Step 2
Opening the outer plastic bag



Step 3
Opening the inner plastic wrap

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