



CLASSIFICATION : AWS A/SFA 5.20 E 71 T1

CHARACTERISTICS :

A flux cored wire suitable for all position welding with higher deposition rate than solid wire. The wire produces high quality welds & gives stable arc with very low spatter & excellent slag detachability.

APPLICATIONS :

Welding of mild steels, carbon steels with UTS upto 50 kg/mm², structural steels, ships, bridges, towers, vehicles, rolling stocks, chemical plant & machinery, wagons, steel frames etc.

Weld Metal Chemistry (%)	C	Si.	Mn	S	P
	0.12 max	0.90 max	1.75 max	0.030 max	0.030 max

Typical Mechanical Properties : of all Weld Metal	UTS Kgf/mm ²	YS Kgf/mm ²	% Elongation (L=4xd)	Charpy-V Impact Value at - 18 deg. C Kgfm
	58	50	24	4

Shielding Gas	: CO ₂ or Ar/CO ₂	10-15 Lit./min.
Deposition Efficiency %	: ~90	

Welding Current and Packing Data :

Dia mm	1.2	1.6
Current Condition	DC+	
Current Amps	150-340	170-395
Welding Position	F, H, V-UP, OH	
Spool Size	300 mm ODx50.5 mm IDx103 mm Width	
Net Weight	15 kgs. Per Spool	



CLASSIFICATION: AWS A/SFA 5.20 E 71 T5

CHARACTERISTICS :

A basic flux cored wire depositing sound radiographic quality weld metal. Deposits are highly crack-resistant and tough. Wire gives stable arc with easy deslagging.

APPLICATIONS :

Welding of structural and boiler-quality steels, with UTS upto 60 kg/mm²

Weld Metal Chemistry (%)	C	Si.	Mn	S	P
	0.12 max	0.60 max	1.75 max	0.030 max	0.030 max

Typical Mechanical Properties : of all Weld Metal	UTS Kgf/mm ²	YS Kgf/mm ²	% Elongation (L=4xd)	Charpy-V Impact Value at -20 deg. C Kgfm
	62	55	28	6

Shielding Gas	: CO ₂ or Ar/CO ₂	10-15 Lit./min.
Deposition Efficiency %	: ~90	

Welding Current and Packing Data :

Dia mm	1.2	1.6
Current Condition	DC+	
Current Amps	150-340	170-395
Welding Position	F, H, V-UP, OH	
Spool Size	300 mm ODx50.5 mm IDx103 mm Width	
Net Weight	15 kgs. Per Spool	

