

AK E71T-11

Description: E71T-11 is an all positional, self-shield flux cored wire suitable for multipass welding, can be used vertical down welding. With good welding properties, like less spatter, stable arc, low fume, easy slag removal and excellent bead appearance.

Application: Used to weld carbon steel sheet structures.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	---	---	---	---
Requirement	0.18	0.90	1.75	0.03	0.03	---	---	---	---
Actual Result	0.08	0.25	1.21	0.017	0.024	---	---	---	---

Typical Mechanical Properties:

	Tensile strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact values (J)
Requirement	≥480	≥400	≥ 17	---
Actual Result	530	455	20	---

Recommended welding parameters:

Diameter/ mm	0.8	0.9	1.0	---
Welding voltage/V	15-20	15-20	15-20	---
Welding current/A	80- 150	80- 150	80- 150	---