

AK E71T-1C

Description: E71T-1C is a CO₂ gas shield flux-cored wire used for all positional welding, can also be used for vertical down welding. Good operation properties like easy slag removal, stable arc, less smoke and spatter.

Application: Used to weld Carbon steels and 500MPa grade high strength steels.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	---	---	---	---
Requirement	0.18	0.90	1.75	0.03	0.03	---	---	---	---
Actual Result	0.056	0.35	1.37	0.012	0.019	---	---	---	---

Typical Mechanical Properties:

	Tensile Strength (MPa)	Yield Stress (MPa)	Elongation (%)	Impact Values (J)
Requirement	490-660	≥400	≥22	≥47J(-20°C)
Actual Result	565	480	26	118

Recommended welding parameters:

Diameter/ mm	1.0	1.2	1.6	---
Welding voltage/V	15-20	20-32	20-38	---
Welding current/A	80-150	140-300	180-400	---