

ESAB 71T1

ESAB 71T1 is an all position rutile flux cored wire designed for optimum performance with 100% CO₂ shielding gas. It produces a slag with good coverage that is easily removable as well as a weld metal that is consistently free of slag inclusions and porosity.

Specifications	
Classifications	SFA/AWS A5.20 : E71T-1C EN ISO 17632-A : T 42 0 P C 1 H10
Approvals	ABS : 2Y400 BV : 2Y40 IRS : 2Y40SM LR : 2Y

Welding Current	DC+
Alloy Type	C-Mn

Typical Tensile Properties				
Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
C1 shielding gas				
As Welded	As welded	500 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	-20 °C	40 J
As Welded	0 °C	95 J

Typical Weld Metal Analysis %		
C	Mn	Si
C1 shielding gas		
0.05	1.10	0.45

Deposition Data		
Diameter	Current	Voltage
1.6 mm	160-410 A	22-34 V
1.2 mm	140-300 A	21-32 V

Recommended Welding Parameters
Wire Diameter
1.2 mm
1.6 mm