

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.

Classifications Weld Metal	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

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC+
Alloy Type	C-Mn
Shielding Gas	C1 (EN ISO 14175)

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 shielding gas			
As Welded	500 MPa	550 MPa	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 shielding gas		
As Welded	0 °C	95 J
As Welded	-20 °C	40 J

Recommended Welding Parameters

Wire Diameter
1.2 mm
1.6 mm