



71T-1

Certifications:

AWS A5.20
ASME SFA A5.20

Features

- Smooth spray transfer and outstanding arc stability.
- Excellent weldability at low and high current settings.

Applications

- Designed for welding mild and medium carbon steels in all positions.

Diameters & Packages

Diameter	2 lb	10 lb	11 lb	15 lb	25 lb	33 lb	44 lb	60 lb	440 lb	500 lb	550 lb
0.030		✓									
0.035	✓	✓	✓			✓					
0.045	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓
0.052				✓		✓	✓	✓		✓	
1/16						✓		✓			✓
0.062						✓	✓				
3/32								✓			

Technical Specifications

Typical Chemical Composition:

Chemical	C	Mn	Si	P	S
	0.18 max	1.75 max	0.90 max	0.03 max	0.03 max

Chemical	Cr	Ni	Mo	V	Cu
	0.20 max	0.50 max	0.30 max	0.08 max	0.35 max

Recommended Weld Parameters:

Diameter	Volts	Amps	Shielding Gas
0.035"	20-30	130-280	100% Co2 or 75% Argon + 25% Co2
0.045"	23-30	150-290	100% Co2 or 75% Argon + 25% Co2

Typical Mechanical Properties:

Tensile Strength	Yield Strength	Elongation
90,000 psi	78,500 psi	27%