

Dual Shield 710X-M

Dual Shield 710X-M provides outstanding operator appeal with an easily controlled arc, improved operation at both lower and higher current levels, minimal spatter and easily removed slag. Dual Shield 710X-M is designed to be used with 75/25 Argon CO₂ gas mix.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1MD-H8/T-9MD-H8 SFA/AWS A5.20 : E71T-1C/T-9C H8
Approvals	ABS : 3YSA (H10) CWB : E491T1-GA3-CS1-H8 CWB : E491T1-M20A3-CS1-H8 CWB : E491T1-GA3-CS1-H8 CWB : E491T1-M21A3-CS1-H8 DNV-GL LR : 3YS (M21) MIL : MIL-71T-1M Seismic Certified : "D"
Industry	Barges Industrial and General Fabrication Light Equipment Railcars Civil Construction Ship/Barge Building

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

Welding Current	DC+
Diffusible Hydrogen	< 8 ml/100g
Alloy Type	C Mn steel

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1			
As Welded	470 MPa (68 ksi)	530 MPa (77 ksi)	30 %
M21			
As Welded	510 MPa (74 ksi)	570 MPa (83 ksi)	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1		
As Welded	-18 °C (0 °F)	81 J (60 ft-lb)
As Welded	-29 °C (-20 °F)	45 J (33 ft-lb)
M21		
As Welded	-18 °C (0 °F)	97 J (72 ft-lb)
As Welded	-29 °C (-20 °F)	76 J (56 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.04	1.3	0.5	0.008	0.012

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	TTW Dist.	Deposition Rate
1.2 mm (0.045 in.)	130-265 A	30-32 V	7.62-10.16 m/min (300-400 in./min)	(0.4, in.)	1.2-4.3 kg/h (2.6-9.5 lbs/h)

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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	TTW Dist.	Deposition Rate
1.4 mm (0.052 in.)	135-355 A	28-30 V	3.81-6.35 m/min (150-250 in./min)	13.0 mm (0.5, in.)	1.4-6.0 kg/h (3.1-13. lbs/h)
1.6 mm (1/16 in.)	185-400 A	30-32 V	8.89-11.43 m/min (350-450 in./min)	16.0 mm (0.6, in.)	2.2-7.5 kg/h (4.9-16. lbs/h)