

Dual Shield 7100SR

FCAW wire for mild steel and 490N/mm² class high tensile steel. Dual Shield 7100SR is an all position flux cored wire with a uniquely balanced formulation to provide greater deposition and improved welding productivity. This wire has good mechanical properties in stress relieved condition as well as in as welded.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1C-9C-J/12C-J H4 JIS Z 3313 : YFW-C502R/YFL-C503R KS D 7104 : YFW-C502R/YFL-C503R
Approvals	ABS : 4YSA H5 (C1) BV : SA4YM H5 (C1) CCS : 4YS H5 (C1) ClassNK : KSW54G(C)H5 DNV : IV YMS H5 (C1) GL : 4Y H5S (C1) KR : 4YSG(C)H5 (C1) LR : 4YS H5 (C1)

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding Gas			
As Welded	451 MPa	541 MPa	31 %
PWHT	435 MPa	520 MPa	31 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
C1 Shielding Gas		
As Welded	-30 °C	152 J
PWHT	-30 °C	128 J
PWHT	-40 °C	85 J
As Welded	-46 °C	88 J
As Welded	-40 °C	123 J
PWHT	-46 °C	75 J

Typical Weld Metal Analysis %

C	Mn	Si	Ni
0.03	1.24	0.42	0.47