

Weld 71T-9

FCAW wire for mild steel and 490N/mm² class high tensile steel. Weld 71T-9 is a multi-purpose all position flux cored wire for use with CO₂ or CO₂ /Ar mixed gas.

Specifications	
Classifications	SFA/AWS A5.20 : E71T-1C/1M/9C/9M-H8 SFA/AWS A5.36 : E71T1-C1A2-CS1-H8 SFA/AWS A5.36 : E71T1-M21A2-CS1-H8 JIS Z 3313 : YFW-C502R/YFL-C503R KS D 7104 : YFW-C502R/YFL-C503R
Approvals	ABS : 3YSA H10 CWB : E491T-9-H8/E491T-9M-H8
Industry	Civil Construction Industrial and General Fabrication Mobile Equipment

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

Welding Current	DC+
Alloy Type	C Mn
Shielding Gas	M21, C1 (EN ISO 14175)

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
100% CO₂			
As Welded	495 MPa (72 ksi)	560 MPa (81 ksi)	31 %
75% Ar - 25% CO₂			
As Welded	580 MPa (84 ksi)	620 MPa (90 ksi)	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
100% CO₂		
As Welded	-30 °C (-22 °F)	54 J (40 ft-lb)
As Welded	-20 °C (-4 °F)	84 J (62 ft-lb)
75% Ar - 25% CO₂		
As Welded	-20 °C (-4 °F)	90 J (66 ft-lb)
As Welded	-30 °C (-22 °F)	55 J (41 ft-lb)

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
0.038	1.31	0.55	0.007	0.013

Deposition Data				
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm (0.045 in.)	140-330 A	22-34 V	5.1-15.2 m/min (201-598 in./min)	1.7-5.3 kg/h (3.7-11. lbs/h)
1.4 mm (0.052 in.)	155-390 A	23-35 V	4.5-14.0 m/min (177-551 in./min)	2.2-6.8 kg/h (4.9-15. lbs/h)
1.6 mm (1/16 in.)	170-460 A	24-36 V	3.8-12.7 m/min (150-500 in./min)	2.5-8.3 kg/h (5.5-18. lbs/h)