

Pipeweld 71T-1

An all-positional rutile cored wire for pipe welding. The weld metal has a minimum yield strength of 420 MPa with CO₂ shielding gas and 460 MPa with Ar/CO₂ mixed gas.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1C H4 SFA/AWS A5.20 : E71T-1M H8 EN ISO 17632-A : T 42 3 P C1 1 H5 EN ISO 17632-A : T 46 4 P M21 1 H5
Approvals	ABS : 4YSA H10

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

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	535 MPa	601 MPa	25 %
C1 shielding gas			
As Welded	495 MPa	585 MPa	25 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-40 °C	70 J
C1 shielding gas		
As Welded	-30 °C	65 J

Typical Weld Metal Analysis %

C	Mn	Si
M21 shielding gas		
0.059	1.33	0.63

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
1.2 mm	150-350 A	23-35 V	5.8-20.7 m/min	2.1-7.5 kg/h