Dual Shield Prime 71 H4

A seamless, copper free, cored wire designed to weld thick steel components. The diffusible hydrogen level is consistently below 4ml/100g of deposited weld metal and with the seam of the wire being laser welded this ensures no moisture pick up. The wire is not copper coated which means there is no chance of copper flakes contaminating feed liners, torches and contact tips. Dual Shield Prime 71 H4 is designed to weld medium strength steels (>400 MPa, >68 Ksi yield strength) and provides excellent impact toughness down to -30 degrees C. Dual Shield Prime 71 H4 is designed to be used with Ar/CO2 (M21) shielding gas mixtures.

Specifications	
Classifications	EN ISO 17632-B : T49 3 T12-1 M21 A-U H5 SFA/AWS A5.20 : E71T-1M/9M/12M H4 JIS Z 3313 : T492T1-1MA-U EN ISO 17632-A : T42 3 P M21 1 H5
Approvals	ABS : 3YA H5 ABS : 3YSA H5

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

Welding Current	DC+
Diffusible Hydrogen	<4ml/100g
Alloy Type	C Mn
Shielding Gas	M21 (EN ISO 14175)

Typical Tensile Properties			
Condition	**Yield Strength**	**Tensile Strength**	**Elongation**
M21 Shielding gas			
As Welded	530 MPa	590 MPa	31 %

Typical Charpy V-Notch Properties		
Condition	**Testing Temperature**	**Impact Value**
M21 Shielding gas		
As Welded	-20 °C	90 J
As Welded	-30 °C	75 J

Typical Weld Metal Analysis %		
C	**Mn**	**Si**
0.04	1.45	0.55

Deposition Data				
Diameter	**Current**	**Voltage**	**Wire Feed Speed**	**Deposition Rate**
1.2 mm	170-310 A	25-35 V	6.0-16.5 m/min	2.5-6.2 kg/h
1.6 mm	180-420 A	24-38 V	3.0-13.0 m/min	1.8-7.5 kg/h