

Dual Shield II 71 HI

FCAW wire for mild steel and 490N/mm² class high tensile steel. Dual Shield II 71-HI is a multi-purpose all position flux cored wire for use with CO₂

Specifications	
Classifications	SFA/AWS A5.20 : E71T-1C SFA/AWS A5.20 : E71T-9C-J JIS Z 3313 : T494T1-1CA-U KS D 7104 : YFL-C504R EN ISO 17632-A : T 42 4 P C1 1 H5
Approvals	ABS : 4YSA H5 (C1) BV : SA4YM H5 (C1) CCS : 4YSH5 (C1) CE : EN 13479 ClassNK : KSW54G(C)H5 CWB : E491T1-C1A4-CS1-H4 (E491T-9J-H4) DNV : IV YMS H5 (C1) KR : 4YSG H5 (C1) LR : 4YS H5 (C1) UKCA : EN 13479
Industry	Marine and Offshore Ship/Barge Building Bridge Construction Industrial and General Fabrication Mobile Equipment Pressure Vessels

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

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

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
C1 Shielding gas			
As Welded	520 MPa	585 MPa	31 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
C1 Shielding gas		
As Welded	-30 °C	120 J
As Welded	-40 °C	110 J

Typical Weld Metal Analysis %									
C	Mn	Si	S	P	Ni	Cr	Mo	V	Cu
C1 Shielding gas									
0.035	1.40	0.40	0.006	0.011	0.45	0.02	0.004	0.02	0.01

Typical Weld Metal Analysis %	
Nb	
C1 Shielding gas	
0.01	

MILD STEEL

GAS-SHIELDED FLUX-CORED WIRES (FCAW/MCAW)



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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	TTW Dist.	Deposition Rate
1.2 mm	135-265 A	24-29 V	4.32-13.97 m/min		1.5-4.8 kg/h
1.4 mm	125-350 A	24-30 V	3.3-15.24 m/min	13.0 mm	1.3-6.7 kg/h
1.6 mm	165-415 A	25-31 V	3.43-12.7 m/min	16.0 mm	1.8-7.6 kg/h