

OK E71T-1

A multi-purpose all positional rutile cored wire for use with C1 or M21 shielding gas.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1C H4 SFA/AWS A5.20 : E71T-1M H8 EN ISO 17632-A : T 42 2 P C1 1 H5 EN ISO 17632-A : T 46 2 P M21 1 H10
Approvals	ABS : 3YSA H5 (C1) BV : SA3M, SA3YM H5, A3M, A3YM H5 BV : SA4YM H10, A4YM H10 CE : EN 13479 DNV-GL : III YMS(H5) DNV-GL : III YMS(H10) LR : 3Y H5 (C1) LR : 3YM H5 (C1) LR : 3YS H5 (C1) PRS : 3YS H5 (C1) RINA : 3Y S H5 UKCA : EN 13479

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)

Tensile Properties

Testing Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			
As Welded	490 MPa	580 MPa	26 %
C1 shielding gas			
As Welded	490 MPa	580 MPa	26 %

Charpy Testing

Testing Condition	Testing Temp	Impact Value
M21 shielding gas		
As Welded	-20 °C	95 J
C1 shielding gas		
As Welded	-20 °C	95 J

Deposition Data

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate
1.0 mm	100-300 A	22-35 V	4.5-23.0 m/min	1.2-6.2 kg/h
1.2 mm	150-350 A	23-35 V	5.8-20.7 m/min	2.1-7.5 kg/h
1.4 mm	150-350 A	22-34 V	3.3-11.6 m/min	1.8-6.3 kg/h