



ADVANTAGE™ E71T-1C Flux-Cored Wire



ADVANTAGE™ E71T-1C flux-cored wire is formulated for use with 100% CO₂ and designed for all position welding of carbon steel. It is level wound and features excellent feedability, good penetration and easy slag removal.

Features and Benefits

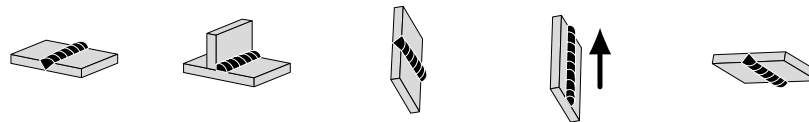
- High deposition
- Excellent mechanical properties
- Easy slag removal
- Low spatter
- Smooth bead surface
- Good weld metal penetration
- All position welding

Classification	Shielding gas
→ AWS A5.20/A5.20M:2005	100% CO ₂
→ E71T-1C/1M-H8	
→ E491T-1-H8	Note: Do not use with Argon/CO ₂ shielding gas.

Applications

- Machinery
- Shipbuilding
- Offshore Construction
- Bridges
- General Fabrication

Welding Positions



Welding Conditions for Mechanical Property Test

Electrode	.045" (1.2 mm)
Wire feed speed (in/min)	300 IPM
Polarity	DC+
Current (A)	200 A
Shielding gas used	100% CO ₂
Preheat temp. °F (°C)	70 (20)
Voltage (V)	25V
Interpass temp. °F (°C)	300 (150)

Typical Chemical Analysis (As Welded)

Weld metal analysis	Typical 100% CO ₂	AWS A5.20
Carbon	0.032	0.12 Max
Silicon	0.48	0.90 Max
Manganese	1.28	1.75 Max
Phosphorous	0.010	0.03 Max
Sulfur	0.008	0.03 Max
Chromium	0.03	0.20 Max
Nickel	0.06	0.50 Max
Molybdenum	0.006	0.30 Max
Copper	0.03	0.35 Max
Vanadium	0.013	0.08 Max

Mechanical Properties (As Welded)

Mechanical tests	Typical 100% CO ₂	AWS A5.20
Tensile Strength	87 ksi (598 Mpa)	70-96 ksi (490-670 Mpa Min)
Yield Strength	81 ksi (555 Mpa)	68 ksi (390 Mpa Min)
Elongation	28%	22% Min

Typical Charpy V-Notch Impact Test Results (As Welded)

CVN temperatures	Typical	ADVANTAGE™ 71C
Avg. at 0°F (-20°C)	44.3 ft-lbs (62 Joules)	20 ft-lbs (27 Joules Min)

Recommended Parameters for Standard Diameters

Wire type	.045 in. (1.2 mm)	.052 in. (1.4 mm)	.062 in. (1.6 mm)
Flat (PA/1G)	120/300A, 27/30V	80/320A, 24/30V	180/400A, 27/33V
Horizontal (PC2G)	140/260A, 27/30V	150/240A, 21/30V	200/360A, 26/31V
Vertical (PF3G)	160/240A, 25/31V	170/310A, 26/30V	180/260A, 27/30V

Linde has a detailed parameter chart available for this product.

Commonly Ordered Part Numbers

Wire type	Diameter (in.)	Packaging	Part number
E71T-1C	0.045	44 lb Spool	ADG71T1C04544
E71T-1C	0.052	44 lb Spool	ADG71T1C05244
E71T-1C	0.062	44 lb Spool	ADG71T1C11644

- Storage** → Store in a dry, enclosed environment
→ Store in its original, intact packaging

ADVANTAGE™ flux-cored welding wire is well protected against moisture – is paper lined and wrapped in plastic, with silica gel.



Step 1
Opening the rugged, glued box



Step 2
Opening the outer plastic bag



Step 3
Opening the inner plastic wrap

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