

BLUECORE 71T

BLUECORE 71T PRODUCT DATA SHEET

CLASSIFICATION		APPROVAL	
AWS A5.20	E 71T-1C	American Bureau Of Shipping Det Norske Veritas Lloyds Register Of Shipping Bureau Veritas	3YSA H10 3Y M8 H10 3YS H10 3Y H10

DESCRIPTION AND APPLICATIONS

BLUECORE 71T is all position rutile cored wire for low risk medium carbon steel. It can be used for 100% CO₂ or 80% Argon 20% CO₂ gas mixture for shielding gas. The slag is easy to remove. The wire give high deposition rate, consistency free from inclusion, porosity and x-ray soundness. This wire is also designed for single and multi pass and perform well over mild scale and normal rust. Application will be on heavy wall thickness structural steel works, pressure vessel, shipbuilding, automotive and construction industries.
Welding Current : DC - EP

Type of Gas : CO₂ , Mixture 80% Argon 20% C O₂
Flow rate : 15-25 (litre/min)

TYPICAL ALL WELD METAL COMPOSITION (Wt%)				
C	Mn	Si	P	S
0.05	1.2	0.46	0.012	0.013

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES•			
YIELD STRESS 480 N/mm ²	TENSILE STRENGTH 570 N/mm ²	ELONGATION 28%	CVN IMPACT VALUES 105J @ -20°C

OPERATIONAL AND PACKAGING DATA					
ELECTRODE SIZE (mm)	WELDING CURRENT RANGE • (amps)	ARC VOLTAGE (V)	WIRE SPEED m/min.	DEPOSITION RATE Kg WELD METAL/ Hr	PACKAGING (kg)
1.2	120 - 280	25 - 40	5 - 25	2.5- 5.5	CTN 15
1.6	150 - 350	25 - 40	5 - 30	3.0- 8.0	15

WELDING POSITIONS :

