

RASI E 71T-1

FLUX CORED WIRE - AWS E 71T-1

CHARACTERISTICS

RASI E 71 T-1 Mild steel flux cored wire with rutile slag base, all position welding, stable arc and good slag detachability with Multi pass welding. The welding can be carried out at a relatively higher welding current density, higher deposition rates are obtained than the solid wire electrodes. The weld bead is characterized by its smooth & excellent appearance.

WELDING POSITIONS

F, H, V-up and OH

CLASSIFICATIONS

SFA 5.20 AWS: E 71 T-1

TYPICAL APPLICATIONS

welding of structural & carbon manganese steels with specified tensile upto 500N/mm² for fabrication of machinery parts, ship building, cranes, steel frames, bridges, towers, etc.

SHIELDING GAS

CO₂
Flow Rate: 10 - 15 litres/min
Current Condition : DC (+)

Chemical Composition of Wled Metal (wt %)

	C %	Mn %	Si %	S %	P %
Typical Results	0.10 max	0.90 - 1.75	0.55 max	0.025 max	0.025 max

All Weld Metal Mechanical Properties :-

	UTS (mpa)	YS (mpa)	Elongation % (L=4xd)	CVN impact at -20C
Typical Results	490 min	390 min	22 min	50 J

Packing Details

Ø 1.00 mm	Ø 1.20 mm	Ø 1.60mm	Ø 2.00 mm	Ø 2.40 mm
---	15 kg spool	15 kg spool	---	---

storage - Store in warm and dry place. *FOR APPROVALS AND CERTIFICATIONS KINDLY CONTACT :- info@rasielectrodes.com
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