BW-71T

Flux Cored Welding Wire

For mild steel and 490N/mm² class high tensile strength steel

AWS A5.20/ASME-SFA A5.20: E71T-1C/1M
AWS A5.36: E71T1-C1A0-M21A0-CS1-H8

Applications & Features

Butt, fillet welding of mild steel & 490N/mm² high tensile strength steels of structure such as ships, bridges, buildings and storage tanks etc.

Characteristics

BW-71T is a titania type flux cored wire designed for all-positional welding for use in single & multi pass applications with both CO2 and Argon/CO2 shielding gas.

It provides excellent usability and a stable arc, less spatter and a good bead appearance, excellent slag removal, and minimal welding fumes as compared to solid wire.

It provides for good welding efficiency thanks to a particularly high deposition rate.

Notes on Usage

The optimum flow for shielding gas is 20-25l/min.

The distance between tip & base metal is to be 20-25mm.

Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.

Thick heavy plate should be welded under proper preheating & interpass temperature.

Welding Position:

All positions

Approvals:

ABS, BV, DNV, GL, LR

Part Numbers:

P/N: 2058 (1.2mm 15kg spool)

P/N: 2059 (1.6mm 15kg spool)

Typical chemical composition of weld metal (%) (Shielding Gas: 100% CO_2 / 75%Ar-25%CO_2)

	C	Mn	Si	S	P	Ni	Cr	Mo	V
AWS A5.20	0.12	1.75	0.90	0.03	0.03	0.50	0.20	0.30	0.08
100% CO_2	0.04	1.35	0.47	0.01	0.01	0.01	0.03	0.01	0.01
75%Ar-25%CO_2	0.04	1.45	0.53	0.01	0.01	0.01	0.03	0.01	0.01

Typical mechanical properties of weld metal (Shielding Gas: 100% CO_2 / 75%Ar-25%CO_2)

	Tensile properties			IV (J)
	YP N/mm² (MPa)	TS N/mm² (MPa)	EL (%)	@-20°C
AWS A5.20	≥ 400	490-660	≥ 22	≥ 27J
100% CO_2	515	595	28.5	101.7
75%Ar-25%CO_2	525	612	28.1	78.0

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Size & recommended current range (DC+)

	Dia. mm (in)	1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp	FLAT, H-FILLET	180~270	200~290	200~320
	V-UP	140~200	160~240	160~260
	O,H	140~220	160~260	160~280