

SL-71TX

Seamless FCAW Wire

For MIG/MAG Cored Wires C-Mn & low alloy steels

betaweld[®]
creating better welding solutions

SL SERIES
SEAMLESS WELDING

Betaweld SL-71TX is a seamless copper coated rutile flux cored wire with an enhanced degree of fill. Due to an easily controllable weld pool, it features outstanding welding properties and -40°C low temperature mechanicals. Betaweld SL-71TX can be welded in all positions with only one parameter setting. The enhanced degree of filling results in much higher current carrying capacity & deposition rate, allowing increased welding speeds to be used which results in time and cost saving. Low spatter and easy slag removal, finely rippled and pore free welds are produced without undercut.

Classification

EN ISO	17632-A: T 46 4 P M 1 H5
EN ISO	17632-B: T 554T1-1MA-UH5
AWS	A5.20: E71T-1M-JH4
AWS	A5.36: E71T1-M21A4-CS1-H4
AS/NZS ISO	17632-B: T554T12-1MA-UH5

Approvals

Grade

ABS	3Y400SA H5
ABS	3Y400SA H5
BV	SA3Y40M H5
BV	SA3Y40M H5
DB	●
DB	●
DNV	IIY40MS H5

Approvals

Grade

DNV	IIY40MS H5
GL	3Y40H5S
GL	3Y40H5S
LRS	3Y40S H5
LRS	3Y40S H5
TÜV	●
TÜV	●



Manufactured in Europe

Current condition and welding position

DC+



Chemical analysis (Typical values in %)

C	Mn	Si	Ni
0.05	1.2	0.55	0.4

Shielding Gas - EN ISO 14175 : M21-ATAL

Materials

Shipbuilding steels A,B,D,E,AH32 to EH36

S(P)235-S(P)460, GP240-GP280

Storage

Keep dry and avoid condensation

All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation A% (%)	Impact Energy ISO - V (J) -40° C
As Welded	≥ 460	550-650	≥ 22	≥ 50

Gas test: M21

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SL-71TX Operating Data

Wire Dia (mm)	Current Range	Voltage Range	Stickout (ESO)	Optimum Amperage	Voltage	Welding Positions
1.2mm	250-300	27-31	20-25	280A	31V	Flat
1.6mm	350-400	27-31	25-30	360A	31V	Flat
1.2mm	230-280	26-30	20-25	260A	28V	HV Fillet
1.6mm	310-360	26-30	25-30	320A	29V	HV Fillet
1.2mm	170-220	24-28	15-20	200A	24V	Vertical Up
1.6mm	200-250	24-28	15-20	240A	25V	Vertical Up
1.2mm	160-210	24-28	15-20	200A	24V	Overhead
1.6mm	190-240	24-28	15-20	220A	24V	Overhead

This operating data is given as a guide only. Actual settings will depend on the machine, material thickness, gas used and the operator techniques.

SL-71TX Packaging Data

Part No	Wire Diameter (mm)	Pack Description	Weight	Pallet Size
2143	1.2mm	Spool/Carton	15kg	62 Spools
2144	1.6mm	Spool/Carton	15kg	62 Spools

