

Tru-Core® FC 71T-AG AWS E71T-1M H8, E71T-9M H8

DESCRIPTION

Tru-Core® FC 71T-AG is a flux cored, gas shielded, all-position electrode, designed specifically for use with gas mixtures of from 75% to 80% Argon/balance CO₂. Tru-Core FC 71T-AG is intended for single and multiple pass applications, for both in-position and out-of-position welding. Up to 80% Argon can be used with no degradation in welding performance or mechanical properties. The arc transfer is small-droplet in nature, with no appreciable spatter deposited. The slag is fluid enough to provide good flow and wetting, but freezes quickly, promoting flat, uniform bead shapes in all positions. Microalloying of the weld metal enhances CVN impact values at lower temperatures.

CHARACTERISTICS

PRODUCT FEATURES:

- Excellent bead appearance in all positions
- Designed for Argon/carbon dioxide blends
- Easy slag removal
- Smooth, spray-like arc transfer
- Excellent feedability
- Excellent mechanical properties
- Fast-freezing slag promotes excellent out-of-position results

MANUFACTURING ADVANTAGES:

- Patented forming, feeding and drawing equipment
- Consistent strip-to-core ratio
- Precise thermal treatment that controls the type, amount and uniformity of surface oxides on the wire
- Consistent diffusible hydrogen levels

PRODUCED IN: Stillwater, Oklahoma

The information contained or otherwise referenced herein is presented only in "typical" without guarantee or warranty, and National Standard expressly disclaims any liability incurred from any reliance thereon. Typical data are obtained when welded and tested in accordance with AWS specifications. Specification, other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique not controlled by National Standard LLC.

SPECIFICATIONS

Meets or exceeds:

- AWS A5.20: E71T-1M H8, E71T-9M H8
- ASME SFA 5.20: E71T-1M H8, E71T-9M H8
- CWB W48-06: E491T-9M-H8

APPLICATIONS

Tru-Core® FC 71T-AG can be used for welding most carbon steels and certain low alloy steels. It is ideal for welding thicknesses varying from 10 gauge sheet metal to heavy plate sections, where "all position" welding capability, stable arc characteristics and excellent mechanical properties are needed. Some examples are:

- Structural Fabrication
- Shipbuilding
- Railcar Construction
- General Fabrication

SHIELDING GAS BLENDS

Typical Application Shielding Gas Blends:

- 75-80% Argon/Balance CO₂
- Flow Rate: 35-45 CFH

WELDING POSITIONS

All position welding is possible when using the correct shielding gas blends, welding process and welding parameters.

STORAGE

Welding wire should be stored in a dry, enclosed environment and in its originally-sealed package.