

ROYAL SUPER 71 (E71T-1C)

AWS A / SFA 5.20 E71T-1C

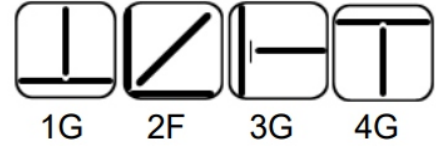
Applications

Royal Super -71 is Rutile type flux cored wire designed for all position single and multipass welding of low and medium carbon steels. Used for welding in bridges, structural fabrication, vehicles, etc.

Characteristics on Usage

Royal Super -71 is designed for optimum performance when using CO₂ shielding. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce fewer fumes, minimal spatter.

Welding Positions



Recommended Stick out
15-20mm

OutShielding Gas

Carbon Dioxide (CO₂) shielding
Gas Flow :20-25 Lit / Min

FLUX CORED WIRE : CARBON STEEL

Chemical Composition Of Weld Metal

C%	Mn%	Si%	S%	P%
0.12Max	1.75Max	0.90Max	0.03Max	0.03Max

Mechanical Properties Of Weld Metal

U.T.S. (N/mm ²)	Y.S. (N/mm ²)	ELONGATION (L = 4d) %	CVN IMPACT AT - 20°C (J)
575-670 Min	390-480 Min	22-26.5Min	27-80Min

Packing and Welding Current

Diameter	Flat	Vertical-Up	Overhead
1.20(mm)	180-250(A) 26-30(V)	120-210(A) 22-26(V)	150-200(A) 26-30(V)

Packing

15 kgs. vacuum packed plastic spool.