

E71T-1C

Conformance

AWS A5.20 E71T-1C

Typical Application

• Used for welding some key structures like shipbuilding, mechanical manufacture, petroleum machinery, chemical machinery, hoisting machinery etc

Mechanical Properties

Tensile Strength (MPa)	Yield Strength (MPa)	Elongation (%)	Impact Energy (J)	Impact Temperature (°C)
560	480	29	77, 95, 83	-20

Chemical Composition %

C	Mn	Si	S	P
0.05	1.36	0.41	0.008	0.012

Reference

Shielding Gas	CO ₂			
Gas Flow Rate (L/min)	20~25			
Diameter (mm)	1.0	1.2	1.4	1.6
Current(A) DC ⁺	120~250	120~300	150~400	180~450

E71T-GS

Conformance

AWS A5.20 E71T-GS

Typical Application

• Used for many kinds of carbon steel base material (Mainly thin plate and galvanized plate), Full position semi-automatic welding, suitable for family type operation.

Mechanical Properties

Tensile Strength (MPa)	Yield Strength (MPa)	Elongation (%)
620	450	23

Chemical Composition %

C	Mn	Si	S	P	Al
0.22	0.62	0.23	0.007	0.008	1.42

Reference

Diameter (mm)	0.8	0.9	1.0
Current(A) DC ⁺	60~130	60~150	60~150
Voltage(V)	14~21	15~22	15~22