

E71T-C1A4-Ni1

Conformance

AWS A5.20 E71T-1C

Typical Application

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

Mechanical Properties

Tensile Strength (MPa)	Yield Strength (MPa)	Elongation (%)	Impact Energy (J)	Impact Temperature (°C)
570	510	27	135/120	-30/-40

Chemical Composition %

C	Mn	Si	S	P	Ni	Cr	Mo	V
0.04	1.28	0.38	0.006	0.011	0.90	≤0.15	≤0.35	≤0.05

Reference

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

E308LT1-1

Conformance

AWS A5.22 E308LT1-1

Typical Application

• Applied in welding corrosion-resistant 06Cr19Ni10, 07Cr19Ni11Ti stainless steel structures and the working temperature should be below 300°C. It used for welding 301,302,304,301L, 308,308L and other stainless steel materials.

Mechanical Properties

Tensile Strength (MPa)	Elongation (%)
550	43.5

Chemical Composition %

C	Mn	Si	P	S	Ni	Cr	Mo	Cu
0.022	1.74	0.60	0.016	0.003	10.35	18.77	0.034	0.08

Reference

Shielding Gas	CO ₂			
Gas Flow Rate (L/min)	20~25			
Diameter (mm)	1.2	1.6		
Current(A) DC ⁺	160~240	180~270		