

MILD STEEL GAS SHIELDED FLUX CORED WIRE

STAR E71T-1 is a rutile based flux cored wire conforming to
AWS SFA 5.20 E71T-1 C/M / SFA 5.36 E71T1-C1A0-CSI/SFA 5.36 E71T1-M21A0-CSI

APPLICATION
Welding Of mild steel and carbon steel for machinery fabrication, frames, construction structures, ship building items.

TYPICAL ALL WELD MECHANICAL PROPERTIES(WITH CO2 SHIELD)

UTS	YS	ELONGATION (L=4d)%	CVN impact Value at -30°C
520 N/mm ²	480 N/mm ²	27	55 J

WELD METAL CHEMISTRY WITH CO2 SHIELD

C	Mn	Si	S	P
0.10% Max	1.00 to 1.60%	0.55% Max	0.025% Max	0.025% Max

WELDING POSITION :



WELD PARAMETER SETTING FOR FLAT WELDING (F) AND POSITION WELDING (P)

SIZE IN MM	VOLT	AMPS	GAS FLOW IN LPM	STICK OUT in mm
1.2	22-26 (F)	180-300(F)	100 % CO ₂ OR 80%Ar+20%co ₂	15-20
	18-22(P)	100-150(P)	100 % CO ₂ OR 80%Ar+20%co ₂	15-20
1.6	25-30 (F)	220-350(F)	100 % CO ₂ OR 80%Ar+20%co ₂	15-20
	18-22(P)	125-200(P)	100 % CO ₂ OR 80%Ar+20%co ₂	15-20

POLARITY	SIZE (MM)	PACKING
DCEP	1.20 and 1.60	15 kgs spool is vacuum packed in a shrink wrapped corrugated box.

CHARACTER

Rutile based flux coated wire suitable for all position welding with DC electrode positive. The wire produces a full slag coverage and excellent slag detachability. The welding arc is smooth and stable with low spatter and good head appearance.