



MILD STEEL GAS SHIELDED FLUX CORED WIRE

STAR E71T-5 flux cored wire conforming to

AWS SFA 5.20 E71T-5 / SFA 5.36 E71T5-C1A2-CS1-H4/SFA 5.36 E71T5-M21A2-CS1-H4.

APPLICATION
Welding of boiler, fabrication and structural steels. It is recommended for multi-pass welding of thicker sections and pressure vessels.

TYPICAL ALL WELD MECHANICAL PROPERTIES(WITH CO2 SHIELD)

UTS	YS	ELONGATION (L=4d)%	CVN impact Value at -30°C
510 N/mm ²	420 N/mm ²	23	70 J

WELD METAL CHEMISTRY WITH CO2 SHIELD

C	Mn	Si	S	P
0.10% Max	1.00 to 1.50%	0.60% Max	0.03% Max	0.03% 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

Flux cored wire with highly basic slag having stable and smooth arc, good slag detachability. It produces radiographic quality welds with very low level of Hydrogen < 5ml per 100gms of weld metal.

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