

# SUNCOR 71T-1

FCAW Wire for C-Mn Steel



## CLASSIFICATION

AWS/A 5.20 : E71T-1C  
Approval : THERMAX

## CHARACTERISTICS

SUNCOR 71T-1 is a superior quality Flux Cored Wire suitable for high quality single and multi pass welds with all positions welding capability. It is further characterized by smooth weld bead, easy slag removal, low fumes and minimal spatters with high deposition rate and produces radiographic quality welds.

## APPLICATIONS

SUNCOR 71T-1 is recommended for welding of C-Mn steel with tensile strength upto 500 N/mm<sup>2</sup> and finds its typical application in storage tanks, structural steels, construction equipments, farm machinery, bridges, ship-building, tower, cranes, chemical plant machinery and general carbon steel fabrication.

## SPECIFIED CHEMICAL COMPOSITION OF BARE SOLID WIRE (%):

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.10 max	1.75 max	0.90 max	0.025 max	0.025 max

## SPECIFIED MECHANICAL PROPERTIES OF ALL WELD METAL :

Yield Strength (N/mm <sup>2</sup> )	Ultimate Tensile Strength (N/mm )	Elongation (%) GL = 4d	CVN Impact at -30°C ( Joules )
390.0 min	490 - 670	22.0 min	47 min

## PACKING DATA :

Diameter ( mm )	Voltage ( Volts )	Current ( DC + ) ( Amp )	KG / spool
1.20	20-32	142-280	15 Kg
1.60	24-35	200 - 360	15 Kg

**SHIELDING GAS :** Carbon dioxide ( CO<sub>2</sub> ) at 8-16 Liters / minute.