

# SUNCOR 71T-5

Basic type FCW Wire for 500 N/mm<sup>2</sup> Tensile Strength Steel



## CLASSIFICATION

AWS/A 5.20 : E71T-5C

## CHARACTERISTICS

SUNCOR 71T-5 is a basic type gas shielded FCW wire suitable for high quality single and multi pass welding of thicker sections with stable arc, easy slag removal, smooth and porosity free weld. It has very low level of H<sub>2</sub> content with crack resistant and tough welds especially when welding steels with high carbon content. It has all position capability and provides radiographic weld quality.

## APPLICATIONS

SUNCOR 71T-5 is suitable for welding of structural and boiler quality steels with minimum UTS upto 510 N/mm<sup>2</sup> and welding of heavy sections in pressure vessels, construction equipments, Off-shore structures, bridges etc.

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

Carbon	Manganese	Silicon	Sulphur	Phosphorus
0.08 max	1.75 max	0.25-0.60	0.03 max	0.03 max

## SPECIFIED MECHANICAL PROPERTIES OF ALL WELD METAL :

Yield Strength (N/mm <sup>2</sup> )	Ultimate Tensile Strength (N/mm <sup>2</sup> )	Elongation (%) GL=4d	CVN Impact at -30°C (Joules)
460 min	530 - 680	22 min	47 avg

Diffusible H<sub>2</sub> content < 4 ml/100 gm

## PACKING DATA:

Diameter (mm)	Voltage (Volts)	Current (DC+)(Amp)	KG/spool
1.2	20-30	130-300	15 Kg
1.6	24-32	180-380	15 Kg

**SHIELDING GAS :** Carbon Dioxide (CO<sub>2</sub>) gas at 10-18 Litres/minute