

## Mild steel rutile cored wire

### Classification

AWS A5.20/A5.20M :E71T-1M- JH8  
 EN 758 :T 46 3 P M 1 H10

### General description

All position gas shielded flux cored wire for high quality welding  
 Excellent operator appeal due to superior welding characteristics  
 Full out-of-position capability with higher deposition rates  
 Exceptional mechanical properties  
 Superior product consistency with optimal alloy control  
 Excellent wire feeding

### Welding positions



ISO/ASME PA/1G PB/2F PC/2G PF/3G up PG/3G down PE/4G

### Current type / Shielding gases

DC +  
 Ar+(>5-25%) CO<sub>2</sub> (EN 439:M21)  
 15-25 l/min

### Typical chemical composition of all weld metal, (w%)

Shielding gases	C	Mn	Si	P	S	H <sub>DM</sub> ml/100g
M21	0.05	1.25	0.7	0.015	0.015	< 8

### Mechanical properties of all weld metal

	Shielding gas	Condition	Yield strength (N/mm <sup>2</sup> )	Tensile strength (N/mm <sup>2</sup> )	Elongation (%)	Impact (ISO), J	
						-30°C	-40°C
Required	AWS A5.20 EN 758		min.400 min.460	min.480 530-680	min. 22 min. 20	min.47	min. 27
Typical values after welding	M21	AW	600	650	24	100	75

### Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm)
Wire reel B300	15	X

Identification Imprint: Revicod®71T-1M

Revicod®71T-1M: rev. EN 20

## Materials to be welded

Steel	Code	Type
General structural steel	EN 10025	S185, S235, S275, S355
Ship plates	ASTM 131	Grade A, B, D, AH32 to EH36
Cast steel	EN 10213-2	G P 240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240NB, L290NB, L360NB, L360QB, L240MB L290MB, L360MB, L415MB, L415NB
	API 5LX	X42, X46, X52, X60
	EN 10216-1/ EN 10217-1	P235T1, P235T2, P275T1 P275T2, P355N
	EN 10028-2	P235GH, P265GH, P295GH, P355GH
Boiler & pressure vessel steel	EN 10113-2	S275, S275, S355, S420
Fine grained steel	EN 10113-3	S275M, S275ML, S355M, S355ML, S420M, S420ML

## Calculation data

Diameter mm	Electrode Stick-out (mm)	Wire feed speed (cm/min)	Current (A)	Arc Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
1.6	20	320	170	21-23	1.9	1.20
		510	235	22-25	3.1	1.20
		635	275	24-26	3.9	1.20
		760	310	25-27	4.7	1.20
		890	350	27-29	5.5	1.20
		1015	385	28-30	6.3	1.20
		1080	400	29-31	6.7	1.20

## Welding parameters, optimum fill , Shielding gases Ar+ (>5-25)%CO<sub>2</sub>

Diameter (mm)	Current (A)	Welding position					
		PA/1G	PB/2F	PC/2G	PF/3Gup	PG/3Gdown	PE/4G
1.6	(A)	250-350	250-350	230-280	220-260	170-240	170-240
	(V)	24-32	24-32	24-30	22-28	22-28	22-28