

Self-shielded cored wire

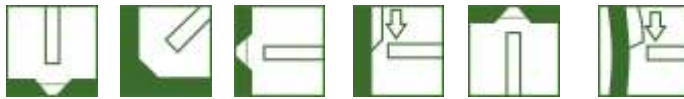
Classification

AWS A5.29/A5.29M :E71T8-K6

General description

Self shielded: easiest equipment arrangement
Vertical down filling semi-automatic pipe welding
High quality construction welding in all positions
Good impact and CTOD toughness

Welding positions



ISO/ASME PA/1G PB/2F PC/2G PG/3G down PF/4G PG/5Gdown

Current type / Shielding gases

DC -

Approvals

BV	DIN	GL	TÜV
SA3YMH	IIIYMSH15	3YH15S	+

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

C	Mn	Si	P	S	Al	Ni
0.07	0.9	0.20	0.005	0.003	1.0	0.85

Mechanical properties of all weld metal

	Shielding gas	Condition	Yield strength (N/mm ²)	Tensile strength (N/mm ²)	Elongation (%)	Impact (ISO), J		
						+20°C	-29°C	-60°C
Required	AWS A5.29		min 400	480-620	20			27
Typical values after welding		AW	420	535	25			110

Packaging, available sizes and identification

Unit type	Net weight/unit (kg)	Diameter (mm)	
		1.7X	2.0
Coils 14C	6.35	X	
Coils 50C	22.8	X	

Identification Imprint: Revishield®71T8

Revishield®71T8: rev. EN 20

Suggestions for use

High productivity welding
 Where arctic mechanical properties are required in general construction welding
 Semi-automatic pipe welding

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 DH36
Cast steel	EN 10213-2	G P 240R
Pipe material	EN 10208-1	L210, L240, L290, L360
	EN 10208-2	L240, L290, L360
	API 5LX	X42, X46, X52
	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, S355
Fine grained steel	EN 10113-2	S275, S355
	EN 10113-3	S275, S355

Calculation data

Diameter mm	Electrode Stick-out (mm)	Wire feed speed cm/min	Current (A)	Voltage (B)	Deposition Rate (kg/h)	kg Wire/kg weld metal
2.0	19	180	175	17.5	1.4	1.27
		230	220	18.5	1.7	1.27
		250	260	19.5	2.5	1.27

Welding parameters, optimum fill

Diameter (mm)	Current / Voltage	Welding position						
		PA/1G	PB/2F	PC/2G	PF/3Gup	PG/3G down	PE/4G	PG/5G down
2.0	(A)	240	240	220		220	185	220
	(V)	21	21	19		19	19	19