

## CORODUR 71T5

CORODUR 71T5 is specially developed basic flux cored wire for all positional welding, which gives radiographic weld metal quality with low hydrogen. It gives superior strength and impact properties. Arc is stable. Low spatter loss with easy slag removal. Using 80%Ar/Balance CO<sub>2</sub> or 100% CO<sub>2</sub> as the shielding gas.

### Applications:

Suitable for Multipass welding on Structural steels, Boiler quality steels, Pressure vessels, Heat Exchanger, Ship-Building, Bridges and Heavy machinery parts.

<b>Classification:</b> SFA/AWS A5.20 – E71T-5C and E71T-5M
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### Typical Chemical Composition:

C	Si	Mn
0.07	0.42	1.35

### Mechanical Properties:

Tensile Strength	Yield Strength	% Elongation	CVN-Impact value at -30°C
525– 655 N/ mm <sup>2</sup>	425N/ mm <sup>2</sup> (min.)	22% (min.)	51 J (min.)

### Welding Parameters:

**Polarity:** DC + ve

**Shielding Gas:** 100% CO<sub>2</sub> or 80%Ar/Balance CO<sub>2</sub>

DIA. (mm)	VOLTAGE	AMPS
1.2	20 – 26	110 – 180
1.4	22 – 28	130 – 220
1.6	24 – 30	160 – 250

### Standard Packing:

Spool = 12.5 kgs(± 1kg) Spool = 15 kgs(± 1kg) Spool = 25 kgs(± 1kg)

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