



WASHINGTON ALLOY'S Quality Management System is Certified to ISO 9001:2008 Cert # 05-R0925

# 71T-1 Carbon Steel Flux-Cored Wire

U.S. ALLOY CO.  
dba Washington Alloy  
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### ALLOY DESCRIPTION AND APPLICATION:

71T-1 is a flux cored wire designed for single or multi pass welding having a smooth arc transfer, low spatter, flat to slightly convex bead contour, with a high deposition rate and easily removal slag. This all-position wire has excellent feeding and low fume generation using 100% CO<sub>2</sub> making it a good choice for mild steel and higher strengths steels. Argon - CO<sub>2</sub> gases may be used if tested with application.

### TYPICAL FCAW WELDING PROCEDURES; DCEP OPTIMUM IN BOLD (FLAT)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO <sub>2</sub> (cfh)
0.035	275- <b>580</b> -780	130- <b>200</b> -260	23- <b>27</b> -30	3/8-3/4"	35-40
0.045	200- <b>450</b> -600	150- <b>250</b> -335	22- <b>29</b> -33	1/2-1"	35-45
0.052	150- <b>400</b> -600	140- <b>275</b> -390	19- <b>28</b> -35	1/2-1"	40-50
1/16"	150- <b>330</b> -490	150- <b>330</b> -475	23- <b>30</b> -38	1/2-1"	40-50
5/64"	120- <b>250</b> -300	250- <b>385</b> -450	26- <b>29</b> -32	3/4-1 1/4"	40-50
3/32"	110- <b>185</b> -275	300- <b>425</b> -550	25- <b>29</b> -34	3/4-1 1/4"	40-50

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

### TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

	AWS Spec.	U.S. ALLOY 71T-1	BASED ON 100% CO <sub>2</sub>		
Carbon	0.12 max	0.03		AWS Spec	Typical
Manganese	1.75 max	1.45	Tensile Strength (psi)	70-95,000	78,000
Silicon	0.90 max	0.30	Yield Strength (psi)	58,000 min.	72,000
Phosphorus	0.030 max.	0.015	Elongation in 2"	22 % min.	28%
Sulfur	0.030 max.	0.010	Charpy V-notch at 0°F	20 ft·lbs min.	55 ft·lbs

**AVAILABLE SIZES:** TCF 71T-1= Spools of .035, .045, .052, 1/16, 3/32

**SPECIFICATIONS;** ANSI/AWS A5.20 E71T-1C, E71T-1M  
ASME SFA A5.20 E71T-1C, E71T-1M  
(Formerly classified as E71T-1)

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