

"HOT-WIRED" FOR PRODUCTION...
the NEW...

"SUPERFLOW" **E71T-1 CO₂**

Uses 100% CO₂!

- +High deposition**
- +Smooth flowing**
- +All position**
- +Low fuming**
- +Low Spatter**
- +Superior wetting**
- +Greater penetration**
- +Single or multi-pass**

**It all adds up to lower
operating costs**



**Vacuum
Packed
For
Freshness**



WASHINGTON ALLOY CO.

www.weldingwire.com

ISO 9001:2000

REGISTERED QUALITY MANAGEMENT SYSTEMS

WASHINGTON ALLOY "SUPERFLOW" E71T-1 CO₂

UNS W07601 AND UNS W07609 / AWS A5.20 E71T-1 / ABS 2SA, 2YSA E71T-1

Washington Alloy's Superflow 71T-1 CO₂ is a general purpose, all-position flux cored wire designed specifically for high production rates in fabrication facilities where time and material costs are major concerns.

Our Superflow 71T-1 CO₂ is designed for use with 100% CO₂ shielding gas, which operates at a greater thermal conductivity than mixed gases, thereby yielding greater penetration in the base metal and superior wetting characteristics. *(We do not recommend the use of a mixed shielding gas on this wire.)*

Our special flux formulation is designed to deposit more metal into the weld itself resulting in an enhanced deposition rate, less spatter, lower fume emissions, and a smooth, stable arc for greater operator appeal.

While the Superflow 71T-1 CO₂ greatly reduces the amount of generated welding fumes during the welding process, Washington Alloy strongly urges the use of ANSI rated respirators and/or fume extractors and to maintain proper ventilation in the welding environment to ensure the lowest possible exposure to welding fumes.

Experience Washington Alloy's Superflow 71T-1 CO₂...it's "hot-wired" for production!

FEATURES:

- *All position welding
- *Enhanced deposition
- *Low fume emissions
- *Greater penetration
- *Smooth flowing
- *Low spatter
- *Lower gas cost

APPLICATIONS:

Using single or multi-pass welds, the Superflow 71T-1 CO₂ is an excellent choice for high tensile steel structures in ship building, bridges, railcars, buildings, dredging equipment, storage tanks, farm equipment, pipe, maintenance and repair, etc.

Also excellent for mild steel plates using butt, fillet or lap welds.

****Excellent Charpy values make The Superflow 71T-1 CO₂ a great choice for cold welding environments.**

TYPICAL CHEMICAL ANALYSIS OF UNDILUTED WELD METAL DEPOSIT

Element	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V	Fe	Other
Maximum Values	Mx	Mx	Mx	Mx	Mx	Mx	Mx	Mx	Mx	Mx	Balance	-
AWS A5.20 E71T-1	.180	1.75	.90	.030	.030	.350	.50	.20	.030	.080		
Deposit – 100% CO ₂	.030	1.48	.75	.012	.009	.022	.030	.039	.010	.020	Balance	-

TYPICAL MECHANICAL PROPERTIES

Stress Test Conducted	Minimum Requirements Per AWS A5.20 E71T-1	Typical Test results 100% CO ₂
Tensile Strength –psi (Mpa)	58,000 Minimum	89,000 ksi
Yield Strength –psi (Mpa)	70,000 Minimum	80,000 ksi
Elongation % in 2" (51mm)	22% Minimum	28%
Charpy V-notch @ -18° C	27 ft-lbs (37J)	48 ft-lbs (65J)

*** Due to the ability of "SUPERFLOW E71T-1 CO₂" to run at high feed speeds with high deposition rates, Washington Alloy strongly recommends the use of bulk welding grade CO₂ or the use of two 50# cylinders linked by manifold to eliminate the possibility of liquid CO₂ induction into the weld caused by the potential increase of shielding gas flow.*

WELDING PARAMETERS

Shielding Gas: 100% CO₂ Flow Rate: 35 - 50 CFH

Wire Stick-out: 1/2" – 1" DC+(Reverse Polarity = Electrode Positive)

Wire Dia. Inch/mm	Position	Wire Feed Speed (approx)	Amps	Volts	Optimum Amps	Optimum Volts
.045 (1.2mm)	Flat/horiz.	375	150-320	23-32	250	30
	Vertical up	260	200-300	22-28	200	26
	Vertical Down	375	200-300	23-32	230	29
	Overhead	260	150-260	22-29	200	28
1/16 (1.6mm)	Flat/horiz.	300	180-450	24-35	350	32
	Vertical Up	160	180-280	24-28	220	26
	Vertical Down	300	250-320	24-32	330	31
	Overhead	160	180-310	24-28	220	26

WASHINGTON ALLOY CO.

Western Regional Office/Warehouse
8535 Utica Ave. (800)830-9033 T
Rancho Cucamonga, CA 91730 (909)291-4586 F

Eastern Regional Office/Warehouse
7010-G Reames Rd (888)522-8296 T
Charlotte, NC 28216 (704)598-6673 F