



Changzhou Giant Welding Co.,Ltd
www.giantweld.com

Standard: AWS A5.20 E71T-GS	Chemical Composition %						
		C	Mn	Si	S	P	Al
Grade E71T-GS	Sample1	0.26	0.91	0.50	0.014	0.016	2.05
	Sample2	0.22	1.00	0.24	0.005	0.015	2.02
Type	Spool (MIG)						
Specification (MM)	0.8、 0.9、 1.0、 1.2、 1.6、 2.0			Package	S100/1kg	S200/5kg	S270/15kg
X - ray detection requirements: II			Deposited metal diffusible hydrogen (Chromatography or Mercury): –				
Mechanical Properties	Yield Strength (Mpa)		Tensile Strength (Mpa)		Elongation(%)		AKV Impact Energy(J) -20℃
	– – –		≥ 490		– – –		– – –
MIG Welding	Diameter （MM）		1.0	1.2	1.4		1.6
	F		80 – 200	160 – 220	170 – 250		180 – 280
Current - A	V – up / OH		55 – 120	120 – 180	140 – 200		160 – 220
Performance characteristics	E71T-GS is a self-shielded flux-cored wire, with good arc stability, vertical direction and good shape of welding pipe. Perfect welding joint can also be obtained when the wind speed is about 10M/S.						
Application	Light weight steel frame, Suitable for low impact value, plate thickness 1.0-4.5 mm welding.						
Notice	1. Welding workpiece should be done oil removal, rust removal treatment. 2. Welding current should be used DCP; note-it is only necessary to change the polarity of the voltage detection line due to the variable-voltage source. 3. When flux-cored wire is welded, the dry elongation should be 10 ~ 20 mm. 4. Welding wire warehouse humidity should be maintained no more than 60%. 5. Non-vacuum packaging wire storage time should not exceed half a year, vacuum packaging wire storage time should not exceed one year.						

