Flux cored wire for welding
WI71

FLUX CORED WIRES FOR WELDING

CHARACTERISTICS:
Flux cored wire.
Welding in all positions with impact at - 20 °C.

MAIN APPLICATIONS:
For welding of mild steel and carbon steel for machinery fabrication, ships, bridges, structures, steel frames etc.
Corresponding steel grades:
A, B, D, to EH.

MAIN ADVANTAGES:
The best compromise for welding in all positions (up, straight or weaving, down, etc.) and for down hand welding. Very good wetting of beads (fatigue resistance).
High deposition in vertical up positions, CO_2 gas.
Good porosity resistance on primer plates.

STANDARDS:

AWS (A 5.20)	AWS (A 5.36)	BS EN ISO	
E 71 T-1C	E 71 T1-C1 A0-CS1-H4	17632-A T 46 2 PC 1 H10	

APPROVALS / HOMOLOGATIONS:

	ABS	BV	DNV-GL	LRS	
With gas C1 (CO_2)					

TYPICAL MECHANICAL ANALYSIS:
ISO all-metal weld tests, without dilution: 250 A, 28 V, 26 cm/min, diam. 1.2 mm. Gas: CO_2
As welded

UTS	MPa	520
YS	MPa	480
Elongation (1=4d)	%	22
CVN at 0 °C	J	90
CVN at -20 °C	J	55

TYPICAL CHEMICAL ANALYSIS:

	C	Mn	Si	S	P
Gas: CO_2	0.10% max	1.0-1.6%	0.55% max	0.025% max	0.02% max

WELDING PARAMETERS:

Diameter mm	D.C + at wire		Voltage V	Positions
	m/min	Intensity A		
1.2	8.6	180	25	Vertical up (string bead)
1.2	10	210	27	Vertical up (wave bead)
1.2	14	280	31	Flat
1.6		350	30	Down hand

GASES USED:
CO_2 15 to 20 l/min.

DIAMETERS / PACKAGING / REFERENCES:

(mm)	Packaging	Weight of wire (kg)	Reference
1.2	BE**	15	1090-5138
1.6	BE**	15	1090-5137