

## Flux Cored Wire

### ***SUPERCORE – 71 T1***

#### ***RUTILE BASE FLUX CORED WIRE***

#### **CLASSIFICATION**

AWS SFA : A 5.20 E 71 T-1 C

#### **CHARACTERISTICS**

SUPERCORE-71 T1 is a superior quality Flux Cored Wire suitable for welding in all position on wide range of welding current under CO<sub>2</sub> shielding. The wire is further characterised by smooth arc, easy slag detachability and produces X-ray quality weld with exceptional Impact strength at sub-zero temperature down to -20° C.

#### **APPLICATIONS**

SUPERCORE-71 T1 is recommended for single and multi pass welding of mild steel and carbon steel, typical applications are storage vessels, ship building, earth moving equipment, piping, heavy machinery, bridges, towers, structural fabrication, vehicles and chemical plant etc.

#### **CHEMICAL COMPOSITION OF ALL WELD METAL (%) (Under CO<sub>2</sub> Shielding)**

<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>S</b>	<b>P</b>
0.12 Max	1.75 Max	0.90 Max	0.030 Max	0.030 Max

#### **MECHANICAL PROPERTIES OF ALL WELD METAL (Under CO<sub>2</sub> Shielding)**

<b>Y.S. Mpa</b>	<b>U.T.S. Mpa</b>	<b>Elongation % (L = 4 x d)</b>	<b>CVN IMPACT STRENGTH AT - 20° C (JOULES)</b>
390.0 Min.	490 - 670	22.0 Min.	27.0 Min.



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### RECOMMENDED PARAMETERS FOR WELDING

(DC with + Polarity for Wire under CO<sub>2</sub> shielding)

Size (mm)	Flat		Vertical Up		Over Head	
	Voltage V	Current A	Voltage V	Current A	Voltage V	Current A
1.20	22-28	180-300	22-26	150-260	23-26	150-250
1.60	24-30	200-400	20-28	180-280	22-28	180-300

### PACKING DETAILS

- Welding Position** : All Position Welding
- Shielding Gas** : Carbon di-oxide (CO<sub>2</sub>) at 8 - 12 Liters / minute
- Sizes Available (mm)** : 1.20, 1.60 mm, other sizes are also available on request.
- Packing** : Supplied on plastic spool of 12.5 Kg / 15.0 Kg Approx. weight.  
Each spool is packed in sealed air tight polythene bag an then packed in protective card board box. Other type of packing is also available on request.
- Recommended Stick-out** : 15 - 20 mm

