

Flux Cored Wire

SUPERCORE – 71 T5

BASIC TYPE FLUX CORED WIRE

CLASSIFICATION

AWS SFA : A 5.20 E 71 T-5 C

CHARACTERISTICS

SUPERCORE-71 T5 is highly basic type Flux Cored Wire having excellent mechanical properties and producing Radiographic quality crack resistant weld having very low level of diffusible hydrogen. Arc is stable and smooth, easy to remove slag and weld bead is sound and uniform.

APPLICATIONS

SUPERCORE-71 T5 is recommended for welding of boiler quality plates, structural steels, pressure vessels etc.. Highly suitable for multipass welding of thicker section and on other applications where high impact values at low temperature are required.

CHEMICAL COMPOSITION OF ALL WELD METAL (%) (Under CO₂ Shielding)

C	Mn	Si	S	P
0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max

MECHANICAL PROPERTIES OF ALL WELD METAL (Under CO₂ Shielding)

Y.S. Mpa	U.T.S. Mpa	Elongation % (L = 4 x d)	CVN IMPACT STRENGTH AT - 30° C (JOULES)
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 CO₂ shielding)

Size (mm)	Flat		Other Welding Position	
	Voltage V	Current A	Voltage V	Current A
1.20	22-26	180-300	18-22	100-150
1.60	25-30	220-350	18-22	125-200

PACKING DETAILS

Welding Position	:	All Position Welding
Shielding Gas	:	Carbon di-oxide (CO ₂) or Argon + Co ₂ Gas with flow rate of 10-15 liters / minute.
Sizes Available (mm)	:	1.20, 1.60 mm, other sizes are also available on request.
Packing Spool Is	:	Supplied on plastic spool of 12.5 Kg / 15.0 Kg. Approx. weight. Each packed in sealed air tight polythene bag and then packed
Protective Card	:	board box. Other type of packing is also available on request.
Recommended Stick-out	:	15 - 20 MM

