



D & H INDIA LIMITED
Formerly 'D & H Welding Electrodes (India) Ltd'

SUPERCORE 71 T1 & T5 Flux Cored Wire



*High Efficiency - Optimum Productivity
X-ray Quality Sound Weld Metal*

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.

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

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	:	Supplied on plastic spool of 12.5 Kg / 15.0 Kg. Approx. weight. Each spool is packed in sealed air tight polythene bag and then packed in protective cardboard box. Other type of packing is also available on request.
RECOMMENDED STICK-OUT	:	15 - 20 MM

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 CO₂ 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 CO₂ Shielding)

C	Mn	Si	S	P
0.12 Max.	1.75 Max.	0.90 Max.	0.030 Max.	0.030 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 - 20° C (JOULES)
390.0 Minimum	490 - 670	22.0 Minimum	27.0 Minimum

RECOMMENDED PARAMETERS FOR WELDING

(DC with + Polarity for Wire under CO₂ shielding)

Size (mm)	Welding Position					
	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

WELDING POSITION	:	All Position Welding
SHIELDING GAS	:	Carbon di-oxide (CO ₂) 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 and then packed in protective card board box. Other type of packing is also available on request.
RECOMMENDED STICK-OUT	:	15 - 20 MM