GWELD
SEAL OF TRUST

GFC 71

FLUX CORED WIRE

IDENTIFICATION
GFC 71, E71T-1C

CLASSIFICATION
AWS/SFA 5.36: E71T-1C1A1
AWS/SFA 5.20: E71T-1CJ/MJ
EN 758: T46 0 P C 1 H5 ASME– IIC/SFA-5.20-AWS E71T-1CJ/MJ
EN ISO 17632 B: T492T1-1CAH5

DESCRIPTION
Tubular Rutile flux-cored wire for single or multi-pass welding of carbon, carbon-manganese steels and similar types of steels, including fine grain ones, with CO2 shielding gas. This gives good weldability in all positions, excellent bead appearance, less spatter, a fast freezing and easy to remove slag. Deposited welds arc of radiographic quality.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P
0.04 - 0.10	0.90 - 1.50	0.30 - 0.65	0.030 max	0.030 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
490 min	400 min	22 min	-40°C	34

TYPICAL APPLICATIONS

Power Plant equipments, Off-Shore Platforms, Pressure Vessels, Ship building, Railways Wagons, General Fabrication welding, Pipe welding, Bridges, Automobile parts, Tanks etc.

UNALLOYED STRUCTURAL STEEL:

St 32, St 37-2 to St 52-3, ASME/ASTM SA-516-Grade 60/65/70. IS 2062 or equivalent.

DIFFUSIBLE HYDROGEN : 8 ml (approx.) **SHIELDING GAS :** CO2 or 80% Argon + 20% Co2 (M)
FLOW RATE : 14-20 l/min

PACKING PARAMETERS

Size (mm)	Amps DC (+)	Voltage (V)	Weight / Spool (kg)
1.2	200 - 400	22 - 35	15

1.6	200 - 400	23 - 37	15