

GFC 719

IDENTIFICATION

GFC 719, E71T-9C

CLASSIFICATION

AWS/SFA 5.20: E 71T-9C/M

AWS/SFA 5.20: E 71T-12C

DESCRIPTION

Tubular rutile flux-cored wire for single or multipass welding of carbon, carbon-manganese steels and similar grades of steels, including fine grain ones, with CO₂ or 80% Ar + 20% CO₂ mix shielding gas. The good weld ability in all positions, excellent bead appearance, less spatter, a fast freezing and easy to remove slag. Deposited weld metal gives excellent impact properties down to -40°C.

WELD METAL ANALYSIS (RANGE) %

C	Mn	Si	S	P	Cr	Ni	Mo	V	Cu
0.04 - 0.10	0.90 - 1.50	0.30 - 0.65	0.03 max	0.03 max	0.2 max	0.5 max	0.3 max	0.08 max	0.35 max

MECHANICAL PROPERTIES (RANGE)

TS (MPa)	YS (MPa)	EL (%) (L=4D)	CVN Impact Value	
			Temp	Joules
510 min	440 min	22 min	-30°C	50 min
			-40°C	35 min

TYPICAL APPLICATIONS

Ship building, railways wagons, general fabrication welding, Pipe welding, bridges, automobile parts, tanks, ASTM A516 grade 70 or equivalent Storage tanks, etc.

FLOW RATE : 14 - 20 l/min

DIFFUSIBLE HYDROGEN : max 5.0 ml / 100g of weld metal

SHIELDING GAS : 100% CO₂ or 80% Ar + 20% CO₂

PACKING PARAMETERS

Size (mm)	Amps DC (+)	Weight / Spool (kg)
1.2	120 - 300	15
1.6	180 - 400	15