



UNIWELD IND. DE ELETRODOS LTDA

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COMMERCIAL NAME: ESSEN FC 71T1

STANDARD: AWS A5.20: 2005 E71T-1C / ASME SFA5.20 E71T-1C Edition 2015

Review: 01

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Chemical characteristic of the deposited metal	C	Mn	Si	P	S	Cr	Ni	Mo	V	Cu
	0.12% Max.	1.75% Max.	0.90% Max.	0.030% max.	0.030% max.	0.20% Max.	0.50% Max.	0.30% Max.	0.080% max.	0.35% Max.

APPLICATION FIELD	It is a tubular wire Rutile for welding in single pass or multipass, suitable for structural steel, low steel and medium carbon content, heavy general construction and maintenance shops generally being suitable for industries Cement, Ceramics, Mining , steelworks, petrochemical, Sugarcane etc.				
TECHNICAL CHARACTERISTICS	This wire obtains a good deposition rate, stable arc, allowing a good finish of the cord, low splash index, easy removal of the slag and providing and facilitating efficiency in operation.				
MECHANICAL PROPERTIES	Tensile strength: 490-670 MPa Flow limit: 390 MPa (min) Stretching: 22% (Min) Impact Test: 27 J at - 20 ° C				
OPERATIONAL CHARACTERISTICS	Type of current: CC +				
	welding position: All the positions				
	shielding gas: 100% CO2 (16 to 24 liters / min)				
	stickout: 10 to 15 mm				
	Diameter (mm)	Ø1,20	Ø1,60		
	Amps (A)	150-320	180-450		
	Voltage (V)	22 to 32	25 to 35		
	Packaging (kg)	15	15		
WELDING TECHNIQUE	Make cleaning the area to be welded with grinder or using mechanical rotary brush impregnated with mill scale and impurities must be removed not to cause contamination, making the appropriately adjusting the amperage and voltage of the machine according to the diameter to be used to avoid overloading the tank wire and regulate the flow of gas.				