



PRODUCT DATA SHEET

FLUX-CORED GAS-SHIELDED WIRE

HOBART 71T



SUMMARY

- > Fast Freezing Slag
- > Outstanding High-Production Performance
- > Smooth Arc Characteristics
- > Low Diffusible Hydrogen Weld Deposit
- > Low Fumes and Spatter Levels

BENEFITS

Can be used on all-position welds with both single and multiple pass welds on mild and some low alloy steels

DESCRIPTION AND APPLICATION

HOBART 71T is a flux-cored wire designed to be used with CO² gas and it's available for all-position welding with both single and multiple pass welds on mild and 490N/mm² high tensile steels. It provides good impact properties, less fume, stable arc, good slag release and excellent X-Ray inspection.

- > Storage Vessels
- > Machinery
- > Structural Fabrication
- > Piping

CLASSIFICATION

- > AS/NZS ISO 17632-A-T 46 3 P C1 1 H5
- > AS/NZS ISO 17632-B-T 493T1-1CA-U-H5
- > AWS A5.20 E71T-1C H4

OTHER

- > **Type of Current:** Direct Current Electrode Positive (DCEP)
- > **Standard Diameters:** 1.2mm and 1.6mm
- > **Re-Drying:** Not Recommended
- > **Storage:** Product Should be Stored in a Dry, Enclosed Environment, and in its Original Intact Packaging

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

| C | MN | SI | S | P |
|------|------|------|-------|-------|
| 0.05 | 1.30 | 0.45 | 0.008 | 0.015 |

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

| MECHANICAL TESTS | |
|-------------------|------------------|
| Gas Type | CO ² |
| Yield Strength | 540 MPa |
| Tensile Strength | 590 MPa |
| Elongation % | 30% in 2" (51mm) |
| CVN Impact Values | 70J @ -30°C |

PACKAGING DATA

| WIRE SIZE (MM) | PART NUMBER | PACKAGING TYPE |
|----------------|-------------|----------------|
| 1.2 | MIGFCH71T12 | 15kg Spool |
| 1.6 | MIGFCH71T16 | 15kg Spool |

CONFORMANCES & APPROVALS

- > **ABS:** 3YSA H5
- > **Bureau Veritas:** SA3YM H5
- > **DNV:** III YMS
- > **Lloyd's Register:** 3YS H5



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OPERATIONAL DATA

| WIRE SIZE (MM) | WELD POSITION | AMPS | VOLTS | WIREFEED SPEED | DEPOSITION RATE | CONTACT TIP TO WORK DISTANCE (MM) |
|----------------|-------------------|------|-------|----------------|-----------------|-----------------------------------|
| | | | | M/MIN | KG/HR | |
| 1.2 | All Positions | 170 | 23 | 6.6 | 2.0 | 16 |
| 1.2 | All Positions | 185 | 24 | 7.7 | 2.7 | 16 |
| 1.2 | All Positions | 200 | 25 | 7.9 | 2.8 | 16 |
| 1.2 | All Positions | 220 | 25 | 9.7 | 3.4 | 19 |
| 1.2 | Flat & Horizontal | 260 | 27 | 12.7 | 4.0 | 19 |
| 1.2 | Flat & Horizontal | 300 | 29 | 15.0 | 5.6 | 19 |
| 1.6 | All Positions | 180 | 23 | 4.1 | 2.1 | 19 |
| 1.6 | All Positions | 245 | 25 | 4.8 | 3.0 | 25 |
| 1.6 | All Positions | 275 | 26 | 5.7 | 3.5 | 25 |
| 1.6 | Flat & Horizontal | 280 | 27 | 6.0 | 4.2 | 25 |
| 1.6 | Flat & Horizontal | 360 | 28 | 8.4 | 5.4 | 25 |
| 1.6 | Flat & Horizontal | 400 | 30 | 10.9 | 6.5 | 25 |

Maintaining a proper welding procedure - including pre-heat and interpass temperatures - may be critical depending on the type and thickness of steel being welded. See Above: This information was determined by welding using 100% CO₂ shielding gas with a flow rate between 17-24 l/min.

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