



PRODUCT INFORMATION

Hobart 71T Gas Shielded Wire

CONFORMANCES:

AWS A5.20 Class E71T-1C
AS/NZS ISO 17632-B-T492T1-1CA-U-H10

DESCRIPTION:

Hobart 71T is an all-position fluxcored wire designed to be used with 100% CO₂. This all-position wire is extremely versatile for a variety of applications. Hobart 71T can be used on all-position welds with both single and multiple pass welds on mild and some low alloy steels.

APPLICATIONS:

Typical applications include storage vessels, structural fabrication, machinery and piping, etc.

MANUFACTURER'S BRAND NAME APPROVALS:

American Bureau of Shipping	3YSA
Lloyds Register	3YS
DNV	III YMS
BV	SA3YM

SHIELDING GAS:

100% CO₂.

TYPICAL CHEMICAL COMPOSITION:

Carbon	0.049%
Manganese	1.27%
Silicon	0.50%
Phosphorus	0.022%
Sulphur	0.003%

TYPICAL MECHANICAL PROPERTIES:

Yield Strength, MPa 628
 Tensile Strength, MPa 647
 % Elongation in 2" (51mm) 28%

TYPICAL IMPACT VALUES:

Charpy V-Notch
 -20°C 87J Average

WELDING POSITION:



SIZES AND RECOMMENDED CURRENT RANGE (DC<+>)

SUGGESTED WELDING PARAMETERS:

Diameter (mm)	1.2 mm		1.4 mm		1.6 mm	
Parameters						
F	140A - 300A	23V - 36V	150A - 350A	22V - 34V	200A - 400A	24V - 42V
HF	140A - 300A	23V - 36V	150A - 350A	22V - 34V	200A - 400A	24V - 42V
H	140A - 280A	23V - 33V	150A - 280A	22V - 32V	200A - 280A	24V - 30V
VU, OH	140A - 220A	23V - 28V	150A - 230A	22V - 28V	160A - 230A	22V - 28V
VD	230A - 280A	23V - 33V	250A - 300A	28V - 32V	250A - 320A	28V - 32V

Stick out: 15-25(mm), flow rate: 20-25(l/mm):