



PRODUCT DATA SHEET

GAS SHIELDED FLUX CORED WIRE

AUSTFIL 71T



SUMMARY

- > A rutile flux shielded flux cored wire
- > Excellent performance in all positional fillet and butt welding applications
- > Shielding gas – 100% CO₂
- > Polarity - DC +

CLASSIFICATION

- > AS/NZS ISO 17632-B - T492T1-1CA-UH10
- > AWS A5.20: E71T-1 H8

DESCRIPTION AND APPLICATION

Austfil 71T is a rutile flux cored wire designed for excellent performance in all positional fillet and butt welding applications. Austfil 71T is formulated exclusively for use with cost effective CO₂.

Suitable for applications such as storage tanks, structural fabrication, bridge construction, machinery and earthmoving equipment. Suitable for AS/NZS 1554.5 of the structural code; Part 5: Welding of the steel structures subject to high levels of fatigue loading.

OPERATIONAL DATA

Welding parameters shown below are for DC Electrode negative only.

WIRE SIZE (MM)	WELDING CURRENT RANGE (A)	ARC VOLT. RANGE *(V)
1.2	150 - 300	25 - 32

Welding Current DC -

*Voltage is determined by arc current and wire arc length.

Welding currents and voltage shown are operational guides only.

SHIPPING APPROVAL

- > LR 3S
- > 3YS

TYPICAL ALL WELD METAL CHEMICAL ANALYSIS

C	Mn	Si	S	P	Fe
0.03	1.28	0.44	0.01	0.013	Bal

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS

Gas Type	CO ₂
Yield Strength	485 MPa
Tensile Strength	580 MPa
Elongation	26%
CVN Impact Values	93J @ -20 ° C

PACKAGING DATA

WIRE SIZE (MM)	PACK SIZE AND TYPE	PART NO.
1.2	15kg spool	AUSTFIL71T12

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