



PRODUCT DATA SHEET

WCD 7025

GAS SHIELDED FLUX CORED MIG WIRE

AUSTFIL 71T



- ▶ All Purpose Rutile Flux Cored Wire
- ▶ For Both Single or Multiple Pass Welds
- ▶ All Positional Wire
- ▶ Formulated Exclusively For CO₂ Gas

Classifications

AS/NZS 2203.1 ETP-GCp_W503A.CM1H10 (superseded)

AS/NZS ISO 17632 BT 49 2 T1 1 C A O H10*

AWS A5.20 E71T-1 H8

*New classification replaces AS/NZS 2203.1

Description & Applications

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 shielding gas.

Austfil 71T is recommended for general purpose all positional welding of mild, carbon and carbon-manganese steels where excellent weld profile and penetration is required. Suitable for applications such as storage tanks, structural fabrication, bridge construction, machinery and earthmoving equipment. Suitable for AS/NZS 1554.5 2004 of the structural code; Part 5: Welding of the steel structures subject to high levels of fatigue loading.

Operational Data

WIRE SIZE (mm)	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
1.2	130 - 230	25 - 32
1.6	200 - 350	25 - 32

Welding current DC+

Welding parameters shown above are for DC electrode positive using 100% CO₂ shielding gas at a flow rate of 15-20 litres/minute.

* Voltage is determined by arc current and wire arc length. Welding currents and voltage shown are operational guides only.

Shipping Approvals

LRS 3S, 3YS

Typical All Weld Metal Chemical Analysis

C	Mn	Si	S	P
0.03	1.28	0.44	0.01	0.013

Typical All Weld Metal Mechanical Properties

Gas Type	CO ₂
Yield Stress	531 Mpa
Tensile Strength	580 Mpa
Elongation	26%
CVN Impact Values	93J @ -20°C

Packaging Data

WIRE SIZE (mm)	PACK SIZE (kg)	PART NUMBER
1.2	15	71T112S
1.6	15	71T116S

Storage Information

Products should be stored in dry conditions in original sealed undamaged packaging as supplied. The integrity of consumable products can be adversely affected by time and storage conditions and that the detail shown in the batch certificate is true at the time of packaging and is only valid for a LIMITED time. After that time the product may need to be reconditioned or checked to ensure it is suitable for the purpose it is intended to be used for.*

Wire should be stored in A plastic bag when not in use for extended periods. Recommended conditions of storage are minimum temperature of 15°C and humidity of 60% RH.

*NOTE: Refer to Welding Technology Institute of Australia (WTIA), technical 3. care and conditioning of arc welding consumables.

Issue AA

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