



# PRODUCT DATA SHEET

# WCD 7020

## GAS SHIELDED FLUX CORED MIG WIRE

### AUSTFIL 71T-1M



- ▶ Rutile Type Flux Cored Joining Wire, Micro Alloyed
- ▶ Formulated Exclusively for use with Ar/CO<sub>2</sub> Shielding Gas Mixtures
- ▶ Excellent Operator Appeal "Smooth Spray Arc Transfer"
- ▶ Versatile All Positional Capabilities
- ▶ Grade 3 Weld Metal Impact Properties
- ▶ Precision Layer Wound on 15kg Spools

### Classifications

AS/NZS 2203.1 ETP-GMp\_W503A.CM1H10 (superseded)  
 AS/NZS ISO 17632 BT 49 2 T1 1 M A U H10\*  
 AWS A5.20 E71T-1M H8

\*New classification replaces AS/NZS 2203.1

### Description & Applications

An all positional rutile micro alloyed type flux cored welding wire specifically formulated for optimum performance using Argon/CO<sub>2</sub> shielding gas mixtures.

The exceptionally smooth arc performance produces a superb weld for single or multipass welding with low spatter losses in all positions and applications (except vertical down).

Austfil 71T-1M is recommended for the welding of mild, carbon and carbon-manganese medium steels where good impact properties at -20°C are required.

This high deposition wire offers excellent operator appeal for general steel fabrications and constructions such as plate sections, beams, girders, truck chassis/bodies, shipbuilding, earth moving equipment, storage tanks, bridge construction etc.

Recommended shielding gases are:

Argoshield 51/ 52, or Blueshield 7(M1) / 8 (M3) or Argon + 18-25%CO<sub>2</sub> or equivalent.

### Operational Data

WIRE SIZE (mm)	WELD POSITION	WELDING CURRENT RANGE (amps)	ARC VOLTAGE RANGE (volts)*
1.2	Flat	250 - 300	29 - 35
	Flat Fillet	230 - 280	28 - 30
	Vertical - up	170 - 220	24 - 28
1.6	Flat	300 - 350	28 - 34
	Flat Fillet	200 - 350	24 - 34
	Vertical - up	200 - 250	26 - 28

Recommended electrical stick out is 20 - 30mm.

Welding Current DC +

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

The information contained or otherwise referenced herein is presented only as "typical" without guarantee or warranty, and Welding Industries of Australia expressly disclaims any liability incurred from any reliance thereon. Typical data is obtained when welded and tested in accordance with the AWS and or AS/NZS specification. Other tests and procedures may produce different results. No data is to be construed as a recommendation for any welding condition or technique by Welding Industries of Australia.

### Shipping Approvals

LRS 3S, 3YS

### Typical All Weld Metal Chemical Analysis

C	Mn	Si	S	P
0.04	1.20	0.42	0.012	0.013

Ni	Cr	Mo	Cu	Ti	B
0.01	0.06	0.01	0.06	0.07	0.001

### Typical All Weld Metal Mechanical Properties

Gas Type	Ar+25% CO <sub>2</sub>
Yield Stress	487 Mpa
Tensile Strength	565 Mpa
Elongation	25%
CVN Impact Values	103J @ -20°C

In as welded position

### Packaging Data

WIRE SIZE (mm)	PALLET SIZE (kg)	PART NUMBER
1.2	900	71T1M12S
1.6	900	71T1M16S

### 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.\*

Welding wires are not immune to deterioration and should be stored in the bag provided when not in use for extended periods. Recommended conditions of storage are minimum temperature of 15°C and a humidity of 60% RH.

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