

Primacore® LW-71

Key Features

- Excellent mechanical properties
- Vacuum sealed aluminium foil bag packaging, precision layer wound wire
- Designed for welding with C1 shielding gas
- Certified for seismic applications – meets the requirements of AWS D1.8
- Easy slag removal

Typical Applications

- Structural fabrication
- Heavy equipment
- General fabrication
- Construction projects in seismic areas

Conformances

AWS A5.20/A5.20M: E71T-1C H8
E71T-9C H8

AS/NZS ISO 17632-B: T 49 3 T1-1 C A U H10

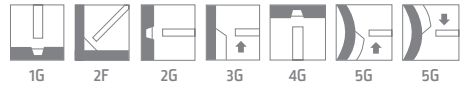
Lloyds Register: 3YSH15

ABS: 3Y H10

DNV: IIIYMS (H10)

AWS D1.8: Meets lot requirements

Welding Positions



Shielding Gas

- 100% CO₂
- Flow Rate: 15-25 L/min

Diameter / Packaging / Settings

Diameter mm	Part Number	Packaging	WFS in/min	Voltage volts	Current amps	CTWD mm
1.2	COPLW71E21-B1	Spool S300 VFB 15kg	180-600	21-33	130-310	15-20
1.2	COPLW71E29	Spool S200 VFB 4.5kg				
1.6	COPLW71E61-B1	Spool S300 VFB 15kg	130-300	22-31	180-345	15-25

Mechanical Properties - As required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
Requirements - AWS E71T-1, E71T-9. As Welded with C1 gas	390 min	490-670	22 min	27 min
Typical Results	559	610	26	85

Deposit Composition

	%C	%Mn	%Si	%S	%P	Diffusible Hydrogen
Typical Results	0.06	1.33	0.39	0.01	0.02	7 ml / 100 g