Primacore® MW-71 H4

Key Features

- Excellent mechanical properties
- Smooth, spray-like metal transfer
- Minimal spatter with easy slag removal
- Designed specifically for use with mixed gas
- Vacuum sealed aluminium foil bag packaging, precision layer wound

Typical Applications

- Welding 490N/mm^2 tensile steels
- Heavy equipment
- General fabrication
- Bridges
- Shipbuilding

Conformances

AWS A5.20/A5.20M: E71T-1M-H4 & E71T-9M-H4
AS/NZS ISO 17632-A: T42 3 P M21 2 H5
AS/NZS ISO 17632-B: T49 3 T1 1 M21 A U H5

Welding Positions



Shielding Gas

- 75-80% Argon / balance CO_2
- 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	COPMW71E21-1	S300 VFB 15kg	180-600	21-33	130-310	15-20
1.4	COPMW71E41-1	S300 VFB 15kg	150-450	23-31	150-325	15-20
1.6	COPMW71E61-1	S300 VFB 15kg	130-300	21-31	180-345	15-20

Mechanical Properties - As required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -30°C
Requirements - AWS E71T-1M, E71T-9M. As Welded with M21 gas	390 min	490-670	22 min	27 min
Typical Results	560	600	26	>100

Deposit Composition

	%C	%Mn	%Si	%P	%S	Diffusible Hydrogen (ml/100g)
Typical Results - with M21 gas	0.06	1.37	0.51	0.017	0.008	3.6

Subject to change – this information is accurate to the best of our knowledge at the time of printing.