

FLUXOFIL 71

TOP FEATURES

- Seamless copper coated rutile flux cored wire for welding of mild steels in shipbuilding and steel construction
- Shipbuilding and general applications.
- All positional capability with outstanding performance in positional welding of fillet and butt welds.
- Savings in total welding cost resulting from high deposition rate, easy slag removal and lack of spatters.

TYPICAL APPLICATIONS

- Shipbuilding
- Steel construction

CLASSIFICATION

| | |
|----------------|-------------------------------------|
| AWS A5.20 | E71T-1M-H4 E71T-1C-H4 |
| EN ISO 17632-A | T 46 2 PM21 1 H5 T 46 2 PC1 1 H5 |
| EN ISO 17632-B | T552T1-1MA-UH5 T552T1-1CA-UH5 |

CURRENT TYPE

DC+

WELDING POSITIONS

All positions

SHIELDING GASES (ACC. EN ISO 14175)

| | |
|-----|--------------------------------------|
| C1 | Active gas 100% CO ₂ |
| M21 | Mixed gas Ar+ 15-25% CO ₂ |

APPROVALS

| ABS | BV | RINA | TÜV | DB |
|-----|----|------|-----|----|
| + | + | + | + | + |

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

| C | Mn | Si | P | S |
|------|-----|-----|--------|--------|
| 0.05 | 1.4 | 0.5 | ≤0.010 | ≤0.010 |

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

| | Shielding gas | Condition* | Yield strength (MPa) | Tensile strength (MPa) | Elongation (%) | Impact ISO-V (J) -20°C |
|----------------|---------------|------------|----------------------|------------------------|----------------|------------------------|
| Typical values | M21 | AW | ≥460 | 550-650 | ≥24 | ≥80 |

* AW = As welded

Gas test: 82% Ar + 18% CO₂

PACKAGING AND AVAILABLE SIZES

| Wire diameter (mm) | Packaging | Weight (kg) | Item number |
|--------------------|--------------|-------------|-------------|
| 1.2 | SPOOL (B300) | 16.0 | W000400964 |

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.