

Primacore[®] MW-71

Key Features

- Excellent mechanical properties, with outstanding operation
- Vacuum sealed aluminium foil bag packaging, precision layer wound
- Designed for welding with M21 shielding gas
- Smooth arc
- Minimal spatter and excellent slag removal

Typical Applications

- Structural fabrication
- Heavy equipment
- General fabrication
- Bridges
- Shipbuilding

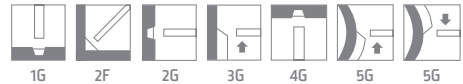
Conformances

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

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

Lloyds Register: 3YS H15

Welding Positions



*Only diameter 1.2 (H8)

Shielding Gas

- 75-80% Argon / balance 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	COPMW71E21	S300 VFB 15kg	180-600	21-33	130-310	15-20
1.6	COPMW71E61	S300 VFB 15kg	130-300	21-31	180-450	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	171

Deposit Composition

	%C	%Mn	%Si	%P	%S	Diffusible Hydrogen
Typical Results - with M21 gas	0.06	1.37	0.51	0.017	0.008	7 mls / 100g