



## SUNCOR 71T1

### CLASSIFICATION:

AWS A 5.20 : E71T-1

### DESCRIPTION:

SUNCOR 71T-1 is an all positional flux cored wire designed for optimum performance when using 100% CO<sub>2</sub> gas. The smooth metal transfer facilitates easy deposition even in positional welding. The slag coverage is complete and easy to remove. Compare to conventional low hydrogen electrodes, SUNCOR absorbs no moisture and ensure much lower H<sub>2</sub> levels in the deposited weld met. The special surface coating provided the wires assure a very long shelf life and easier wire feeding. Weldmet are of radiographic quality.

### TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)				Mechanical Properties	
C	0.06	Mn	1.30	YS	420 N/mm <sup>2</sup>
Si	0.50			UTS	590 N/mm <sup>2</sup>
				EL (L-4d)	22%
				Impact (CVN) at -18° C	50 J

### APPLICATIONS

It is designed for all position single and multipass welding of mild and medium tensile carbon steels upto 510 N/mm<sup>2</sup> for e.g. fabrications in chemicals machinery equipments, structures and steel frames in construction, ship-building, automobile industry, building of heavy infrastructure such as bridges, towers, in steel industry, rolling stocks etc. It performs well over normal rust and mill scale.

### CURRENT RANGE & PACKING DATA:

Size	Current Range	Packaging Per	Winding
(mm)	(Amps)	Carton	
1.2	100-230	15 Kg	Layer to Layer
1.6	150-350	15 Kg	Layer to Layer

### PACKING:

Wires are packed in Plastic Spools weight 15 Kg Per Spool.