



## SUNCOR 71T5

### CLASSIFICATION:

AWS A 5.20 : E71T-5

### DESCRIPTION:

SUNCOR 71T-5 is a fully basic flux cored wire producing very low hydrogen quality weld metal with high resistance to cracking in joints under restraints. The smooth metal transfer facilitates easy deposition even in position welding. The slag system allows for excellent welding in all position with virtually no spatter. There is no inconsistency in fill ratio and higher deposition rates are possible. Weldments are of radiographic quality.

### TYPICAL ALL WELD METAL PROPERTIES:

Chemical Composition (%)				Mechanical Properties	
C	0.05	Mn	1.35	YS	420 N/mm <sup>2</sup>
Si	0.55			UTS	540 N/mm <sup>2</sup>
				EL (L-4d)	25%
				Impact (CVN) at -30° C	50 J

### APPLICATIONS:

All general fabrication work involving the multipass welding of heavy sections in tensile strength upto 530 N/mm<sup>2</sup> e.g. in construction of bridges, pressure vessels and offshore structures boilers quality steels like SA 515-70,285 Grade C,IS:2002-2A and 2B,IS:2062,IS:226 & DIN 17155 HIV.

### CURRENT RANGE & PACKING DATA:

Size	Current Range	Packaging Per	Winding
(mm)	(Amps)	Carton	
1.2	100-250	15 Kg	Layer to Layer
1.6	140-350	15 Kg	Layer to Layer

### PACKING:

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