

Primacore[®] LW-71

Flux Cored Wire - Mild Steel

Key Features

- ▶ Excellent mechanical properties, low fume levels
- ▶ Vacuum sealed aluminium foil bag packaging, precision layer wound wire
- ▶ Designed for welding with C1 shielding gas
- ▶ Certified for seismic applications - meets the requirements of AWS D1.8

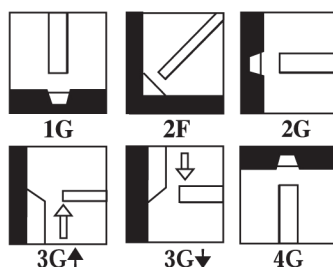
Conformances

AWS A5.20/A5.20M	E71T-1C, E71T-9C
AS/NZS ISO 17632-B	T49 3 T1-1 CAK U H10
Lloyds Register	3YSH15
ABS	3YSA H10
DNV	IIIYMS (H10)
AWS D1.8	Meets lot requirements

Typical Applications

- ▶ Structural fabrication
- ▶ Heavy equipment
- ▶ General fabrication
- ▶ Construction projects in seismic areas

Welding Positions



Shielding Gas

- ▶ C1: 100% CO₂
- ▶ Flow Rate: 15-20 L/min

Diameter / Packaging / Settings

Diameter mm	Spool - S300 VFB 15kg	WFS in/min	Voltage volts	Current amps	CTWD mm
1.2	COPLW71E21-B1	180-550	21-30	130-285	15-20mm
1.6	COPLW71E61-B1	125-400	21-31	190-380	15-20mm

Mechanical Properties - As Required per AWS A5.20

	Yield Strength MPa	Tensile Strength MPa	Elongation %	Charpy V-Notch J @ -29°C
Requirements - AWS E71T-1, E71T-9 As Welded with C1 gas	400 min	490-670 min	22 min	27 min
Typical Results	559	610	26	85

Deposit Composition

	%C	%Mn	%Si	%S	%P
Typical Results	0.06	1.30	0.33	0.01	0.02