

Outershield[®] 71-CX

Flux Cored Wire - Mild Steel

Key Features

- ▶ Excellent mechanical properties, low hydrogen
- ▶ Vacuum sealed aluminium foil bag packaging, precision layer wound wire
- ▶ All positional wire designed for welding with C1 shielding gas
- ▶ Premium arc performance and bead appearance

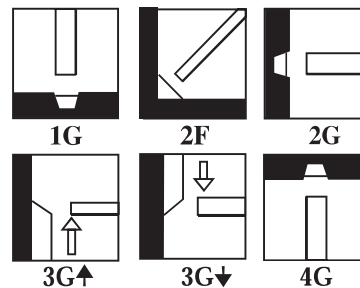
Conformances

AWS A5.20/A5.20M	E71T-1C-H8, E71T-9C-H8
AS/NZS ISO 17632-B	T49 3 T1-1 CAK U H10
Lloyds Register	4YSH10

Typical Applications

- ▶ Medium to heavy mill scale base material
- ▶ Sheet and plate to 450 MPa yield strength
- ▶ General fabrication of carbon manganese steels

Welding Positions



Shielding Gas

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

Diameter / Packaging / Settings

Diameter mm	Spool - S300 VFB 13kg	WFS in/min	Voltage volts	Current amps	CTWD mm
1.2	033602	180-550	21-30	130-285	15-20mm
1.6	033606	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 @ -30°C
Requirements - AWS E71T-1, E71T-9 As Welded with C1 gas	400 min	490-670 min	22	27 min
Typical Results	515	580	29	110

Deposit Composition

	%C	%Mn	%Si	%Ni	%S	%P
Typical Results	0.05	1.36	0.41	0.43	0.009	0.015