

TECHSHIELD 71C

FCAW Welding Wire



➤ **Rutile Flux-Cored Welding Wire For FCAW (MIG) Welding of Mild steel & 490MPa Low Alloy Steels.**

➤ **100% C1 (CO₂) Sheilding Gas.**

DESCRIPTION & APPLICATION:

Corefab® Techshield 71C is a rutile type flux-cored welding wire designed for CO₂ gas shielded FCAW (Flux-Cored Arc Welding) of mild steel and 490 MPa class high-strength structural steels. It is engineered to deliver excellent welding performance, stable arc characteristics, and high deposition efficiency for demanding structural fabrication applications.

TechShield 71C provides smooth and consistent feeding due to its precision layer-wound spooling and vacuum sealed packaging, ensuring reliable welding performance and reduced downtime during operation. Its rutile slag system offers excellent slag detachability, minimal spatter, and attractive weld bead appearance, making it suitable for both productivity and visual weld quality.

STORAGE:

To maintain premium condition, product should be stored in their original packaging in a controlled environment of less than 50% relative humidity. Avoid damp, wet areas.

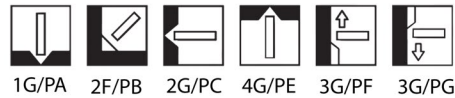
CLASSIFICATIONS:

- AWS A5.20 E71T-1C
- AS/NZS ISO 17632-A: T42 3 P C11 H10
- AS/NZS ISO 17632-B: T49 3 T1-1 C1 H10

APPROVALS:

- ABS: 3YSAH5 ■ BV: S3YH10 ■ DB: T46 2 P C11 H10
- DNV: III YMS (H10) ■ TUV: T46 2 P C11 H10
- 1.2mm Only - ■ LR: 3YSH15 ■ RINA: 3YSH10

POSITIONS:



TYPICAL ALL WELD METAL CHEMICAL ANALYSIS:

C	Mn	Si	S	P	Ni	Cr
0.046	1.23	0.57	0.007	0.014	0.015	0.022
Mo	V	Nb	Cu			
0.015	0.025	0.014	0.027			

TYPICAL ALL WELD METAL MECHANICAL ANALYSIS:

ISO 14175:	-	C1
Yield Strength (Mpa)	-	502
Tensile Strength (Mpa)	-	570
Elongation (%)	-	27
CVN Impact Value (J)	-	118 @ -20°C
	-	88 @ -30°C

PACKAGING DATA

WIRE DIAMETER	PACK SIZE & TYPE	PART NUMBER
1.2mm	5KG Spool	MWFCCF71C1205
1.2mm	15KG Spool	MWFCCF71C1215
1.6mm	15KG Spool	MWFCCF71C1615

OPERATIONAL INFORMATION

WIRE DIAMETER	WELDING CURRENT RANGE	ARC VOLTAGE RANGE*	TYPICAL STICKOUT	GAS FLOW RATE
1.2mm	140 - 305A	21 - 30V	15 - 20mm	18 - 25L/min
1.6mm	190 - 345A	22 - 33V	15 - 25mm	18 - 25L/min

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