



XTR 71T-GS

AWS A5.20 E71T-GS

Description:

E71T-GS is a carbon steel, flux cored electrode for use without an external shielding gas. This electrode is intended for welding thin-gauge carbon steel, ranging from 3/16" to 22 gauge.

Typical Applications:

XTR 71T-GS is intended for single-pass weldments; this product is designed to weld quite effectively over galvanized material and can be used on certain aluminized surfaces as well. E71T-GS requires no external gas-shielding and should be welded with DCEN (straight polarity). Common for home hobbyists, this versatile welding wire is perfect. Not intended for structural steel applications, when application is structural, we suggest E71T-11 or E71T-8 gasless wires.

Chemistry:

	Typical	AWS Spec.
Carbon (C)	0.190	ns
Manganese (Mn)	0.830	ns
Silicon (Si)	0.372	ns
Phosphorus (P)	0.011	ns
Sulfur (S)	0.007	ns
Chromium (Cr)	0.038	ns
Nickel (Ni)	0.061	ns
Molybdenum (Mo)	0.051	ns
Vanadium (V)	0.003	ns
Copper (Cu)	0.042	ns
Aluminum (Al)	1.695	ns



Mechanical Properties: (As Welded FCAW)

	Typical	AWS Spec.
Tensile Strength	86,000	70,000 psi
Yield Strength	74,000	ns
Elongation in 2" (%)	26	ns
Charpy V-Notch	ns	ns

Welding Positions:

All - H, F, VU, VD, OH

Operating Parameters: MIG (FCAW), DCEN DC-

No Shielding Gas					
Diameter	Amperage	Voltage	Speed (IPM)	Stickout (In.)	Flow Rate (CFH)
0.030 (.8mm)	130	16	215	3/8	na
0.035 (.9mm)	150	17	205	1/2	na
0.045 (1.14mm)	190	17	190	1/2	na
1/16 (1.6mm)	230	17	225	3/4	na

When welding in VU, VD or OH positions, amperage should drop by about 25% as well as wire feed speed.

Typically, the wire speed is set, then adjust to voltage to the desirable performance



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