

Lincoln 71T1M

TOP FEATURES

- Rutile gas shielded flux cored wire for welding with CO₂ shielding gas
- Very good weldability in positional welding
- CVN > 47J at -20°C

TYPICAL APPLICATIONS

- Fillet and butt welds in shipbuilding and general steel construction

CLASSIFICATION

AWS A5.20 E71T1-M
EN ISO 17632-A T 46 2 P C 1 H5

CURRENT TYPE

DC+

WELDING POSITIONS

All except vertical down

SHIELDING GASES (ACC. EN ISO 14175)

M21 Mixed gas Ar+ (>15-25%) CO₂
Flow rate 15-25 l/min

APPROVALS

ABS	LR	DNV	RINA
in development	in development	in development	in development

CHEMICAL COMPOSITION (WEIGHT %), TYPICAL, ALL WELD METAL

Shielding gas	C	Mn	Si	P	S
M21	0,05	1,50	0,50	0,015	0,010

MECHANICAL PROPERTIES, TYPICAL, ALL WELD METAL

	Shielding gas	Condition*	Yield strength (MPa)	Tensile strength (MPa)	Elongation (%)	Impact ISO-V (J) -20°C
Required: AWS A5.20			min. 400	490-660	min. 20	min. 27
EN ISO 17632-A			min. 460	530-680	min. 20	min. 47
Typical values	M21	AW	575	640	23	90

* AW = As welded

PACKAGING AND AVAILABLE SIZES

Wire diameter (mm)	Packaging	Weight (kg)	Item number
1.2	SPOOL (S200)	5.0	COARLC71TE23
	SPOOL (S300)	15.0	COARLC71TE21

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.

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