

**VERTI-COR 71T**



- ▲ Precision layer wound (PLW).
- ▲ Rutile type flux cored wire formulated for use with Argon +18 to 25% CO<sub>2</sub> and 100% CO<sub>2</sub> shielding gas.
- ▲ Versatile, all positional capabilities.
- ▲ Excellent Operator Appeal.
- ▲ Low spatter and fume levels.

**Classifications:**

AS/NZS: 17632 (new)      BT 49 3 T1 1 M/C AU H10  
 AWS/ASME-SFA A5.36:    E71T1-M21/C1A3-CS1-H8

**Description and Applications:**

Verti-Cor 71T is a smooth running all positional flux cored wire which offers improved operator appeal and lower fume and spatter levels under welding grade Argon + 18 to 25% CO<sub>2</sub> and 100% CO<sub>2</sub> shielding gas.

Precision layer wound (PLW) on plastic spools, Verti-Cor 71 T offers significant welding improvements compared with conventional E71T-1 wires, in particular 50-60% less spatter, ~20% less fume and improved wire feeding.

Verti-Cor 71T is designed for the single and multi-pass welding of mild and medium strength steels in the downhand, vertical-up and overhead positions. It is recommended for general steel construction and fabrication welding where the work cannot be rotated to the downhand positions.

**Typical Weld Metal Mechanical Properties:**

Actual weld metal mechanical properties achieved with Verti-Cor 71T are influenced by many factors including, base metal analysis, welding parameters/heat input used, shielding gas selection, number of weld passes and run placement, etc. Please consult your nearest CIGWELD distributor for welding procedure recommendations.

**APPROVALS\*:**

Lloyds Register of Shipping      Grade 3YS H  
 American Bureau of Shipping    Grade 3YSA H  
 \* with welding grade CO<sub>2</sub> shielding gas.

**TYPICAL ALL WELD METAL ANALYSIS:**

C: 0.04%      Mn: 1.24%      Si: 0.55%      Fe: Bal

**TYPICAL DIFFUSIBLE HYDROGEN LEVELS TO AS3752:**

5.0-7.0mls of hydrogen /100gms of deposited weld metal\*.

\*For 'as manufactured' product with an electrode stickout of 20mm with 1.2mm wire and 25mm with 1.6mm wire and middle of the range current and voltage settings.

**TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:**

Yield Stress	490 MPa
Tensile Strength	556 MPa
Elongation	28%
CVN Impact Values	>47J av @ -30°C 100J av @ -20°C

**RECOMMENDED SHIELDING GASES:**

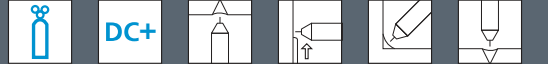
Ar + 18 to 25% CO <sub>2</sub>	ISO14175: M21
100% CO <sub>2</sub>	EN439:
C1	

**Packaging Data:**

Wire Diameter (mm)	Type	Pack Weight	Pack Part No.
1.2	Plastic Spool - PLW*	15kg	720800
1.6	Plastic Spool - PLW*	15kg	720802

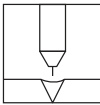
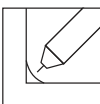
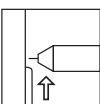
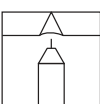
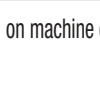



\*PLW = Precision Layer Wound

**VERTI-COR 71T CONT.**



**Operating Data:**

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO<sub>2</sub> shielding gas with a flow rate of 10-15 litres/min.

Wire Diameter mm	Current Range (amps)	Voltage Range (volts)	CTWD	Welding Positions
1.2	225-300	27-31	25-30	 Flat
1.6	320-400	27-31	25-35	 HV Fillet
1.2	225-275	26-30	25-30	 HV Fillet
1.6	300-350	26-30	25-30	 HV Fillet
1.2	175-225	24-28	25-30	 Vertical Up
1.6	200-250	24-28	25-30	 Vertical Up
1.2	175-225	24-28	25-30	 Overhead
1.6	200-250	24-28	25-30	 Overhead

These machine settings are a guide only. Actual voltage, welding current and CTWD used will depend on machine characteristics, plate thickness, run size, shielding gas and operator technique etc.