



VERTI-COR 71T PRODUCT DATA SHEET



SMOOTH RUNNING ALL POSITIONAL FLUX CORED WIRE



FLUX CORED ARC WELDING (FCAW) WIRES

VERTI-COR 71T

- Precision layer wound (PLW).
- Rutile type flux cored wire formulated for use with Argon +18 to 25% CO₂ and 100% CO₂ shielding gas.
- Versatile, all positional capabilities.
- Excellent Operator Appeal.
- Low spatter and fume levels.

CLASSIFICATIONS:

ISO AS/NZS 17632:

B T 49 3 T1 1 M/C AU H10

RECOMMENDED SHIELDING GAS:

AR + 18 TO 25% CO₂ 100% CO₂ IS014175: M21 EN439: C1

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

USING ARGON + 18-25% CO_2 :	
Yield Stress	490 MPa
Tensile Strength	556 MPa
Elongation	28%
CVN Impact Values	> 47J av @ -30°C 100J av @ -20°C

TYPICAL ALL WELD METAL ANALYSIS:

USING ARGON + 18-25% CO ₂ :				
C:	0.04%			
Mn:	1.24 %			
Si:	0.55%			
Fe:	Balance			





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% CO₂ and 100% CO₂ 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 7IT 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.

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.

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
1.6	Drum	200kg	720802A

OPERATING DATA:

All welding conditions recommended below are for use with semi-automatic operation, DC electrode positive and welding grade CO₂ shielding gas with a flow rate of 10-15 litres/min.

WIRE DIAMETER (MM)	CURRENT RANGE (AMPS)	VOLTAGE RANGE (VOLTS)	CTWD	WELDING Position	
1.2 1.6	225-300 320-400	27-31 27-31	20-30 25-35		Flat
1.2 1.6	225-275 300-350	26-30 26-30	25-30 25-30		HV Fillet
1.2 1.6	175-225 200-250	24-28 24-28	25-30 25-30		Vertical Up
1.2 1.6	175-225 200-250	24-28 24-28	25-30 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.





