

Characteristics and Applications:

HOBART 71T is a flux-cored wire designed to be used with CO₂ gas and it's available for all-position welding with both single and multiple pass welds on mild and 490N/mm² high tensile steels. It provides good impact properties, less fume, stable arc, good slag release and excellent X-Ray inspection. Typical applications include shipbuilding, storage vessels, structural fabrication, machinery and piping etc.

Notes on Usage:

1. Use DC(+) polarity.
2. Use CO₂ (more than 99.8% purity) as shielding gas.
3. Keep dry while in storage and delivery.

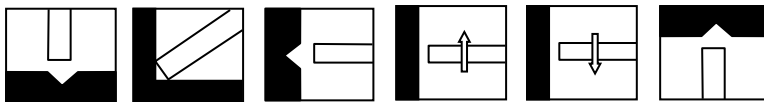
Typical Chemical Composition of Weld Metal (Wt%)

	C	Mn	Si	P	S
AWS	≤ 0.12	≤ 1.75	≤ 0.90	≤ 0.03	≤ 0.03
EN ISO	-	≤ 2.0	-	-	-
Typical value	0.05	1.30	0.45	0.015	0.008

Typical Mechanical Properties of Weld Metal

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J(ft-lbf)	
				-20°C (0°F)	-30°C (-20°F)
AWS	≥ 390(58)	490-670(70-95)	≥ 22	≥ 27(20)	≥ 27(20)
EN ISO	≥ 460(67)	530-680(77-99)	≥ 20	≥ 47(35)	-
Typical value	540(78)	590(86)	30	100(74)	70(52)

Welding Position



Sizes and Recommended Operating Range (DC <+>)

Stick Out:15-25(mm), Flow Rate:20-25(l/min)

Diameter (mm)	1.2	1.4	1.6
Position			
F, HF	140A~300A / 23V~36V	150A~350A / 22V~34V	200A~400A / 28V~42V
H	140A~280A / 22V~33V	150A~280A / 22V~32V	200A~400A / 28V~42V
VU, OH	140A~220A / 22V~28V	150A~230A / 22V~28V	160A~280A / 22V~28V
VD	230A~280A / 28V~33V	250A~300A / 28V~32V	250A~320A / 28V~32V

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