# **ROYAL SUPER 71 (E71T-1C)**

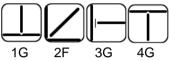
## **Applications**

Royal Super -71 is Rutile type flux cored wire designed for all position single and mulipass welding of low and medium carbon steels. Used for welding in bridges, structural fabrication, vehicles, peb etc.

# **Characteristics on Usage**

Royal Super -71 is designed for optimum performance when using CO2 shielding. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness. This wire is formulated to produce fewer fumes, minimal spatter.

# Welding Positions



#### **Recommended Stick Out**

15 - 20mm

#### **Shielding Gas**

Carbon Dioxide (CO2) shielding Gas Flow :20-25 Lit / Min

#### **Chemical Composition Of Weld Metal**

| Element           | C%       | Mn%      | Si%      | S%       | P%       |
|-------------------|----------|----------|----------|----------|----------|
| Typical<br>Values | 0.045    | 1.20     | 0.35     | 0.010    | 0.020    |
| Spec.<br>Reqd.    | 0.12 Max | 1.75 Max | 0.90 Max | 0.03 Max | 0.03 Max |

#### **Mechanical Properties Of Weld Metal**

| Property       | Property U.T.S. |         | ELONGATION   | CVN IMPACT      |  |
|----------------|-----------------|---------|--------------|-----------------|--|
|                | (N/mm²)         | (N/mm²) | ( L = 4d ) % | AT - 20°C ( J ) |  |
| Typical Values | 575             | 480     | 26.5         | 80              |  |
| Spec. Reqd.    | 490-670         | 390 Min | 22 Min       | 27 Min          |  |

### Welding Parameters (DC + VE)

| Diameter | Flat    |       | Vertical - Up |       | Overhead |       |
|----------|---------|-------|---------------|-------|----------|-------|
| (mm)     | (A)     | (V)   | (A)           | (V)   | (A)      | (V)   |
| 1.20     | 180-250 | 26-30 | 120-210       | 22-26 | 150-200  | 26-30 |

#### **Packing**

15 kgs. vaccum packed plastic spool.