

# CHT71Ni

Flux Cored Wire for High Tensile Steel

AWS A5.20 E71T-1/9 C-J  
BS EN ISO 17632 T42 4 P C 1 H10  
GB/T 10045 E501T-1L

**Type of Flux:** Rutil

**Welding Position:** F, H, HF, OH, V, VD

**Type of Current:** DCEP

## Features & Applications

E71-1/9 CJ is used for structures fabricated by mild steels and high tensile strength steel with 490MPa grade, such as ships, offshore platforms, pressure vessels, pipes and so on. The weld metal is with good plasticity and low temperature impact toughness.

## Chemical Composition of Deposited Metal (%)

	C	Mn	Ni	Si	S	P
Standard	≤0.18	≤2.00	≤0.50	≤0.90	≤0.03	≤0.03
Atlantic	0.04	1.30	0.45	0.35	0.008	0.014

## Mechanical Properties of Deposited Metal (AW)

	Yield Strength ReH (MPa)	Tensile Strength Rm (MPa)	Elongation A4 (%)	Impact Value (J)		Shield Gas
				-20	-40	CO <sub>2</sub>
Standard	490~670	≥390	≥18	—	≥27	purity≥99.98%
Atlantic	520	425	30	—	110	

The standard of mechanical properties conforms to shipping institutions and the certificate of inspection would follow it unless the purchaser has special requirement.

**X-ray radiographic inspection:** Grade II

## Recommended Current (DC<sup>+</sup>)

Diameter(mm)	1.2	1.4	1.6
Current (A)	100-280	110-300	120-340
Voltage(V)	20-32	21-35	22-40

- Notice:**
- 1) The flow rate of shield gas should be within 20L-25L/min in welding.
  - 2) The wire extension should be within 15mm-25mm.
  - 3) The surfaces to be welded must be cleaned away impurities of oil contamination, rust, moisture and so on.
  - 4) Using CO<sub>2</sub> gas protection, The purity of CO<sub>2</sub> gas must be more than 99.95%.
  - 5) Preheating and interpass temperature 150°C ± 15°C