

FEATURES

- Superior arc performance and bead appearance
- Excellent weldability with low fume output
- Design for welding with 100% CO2 shielding gas
- Premium X-ray quality welds

APPLICATION

Golden Weld 71T-1C is an all-position flux cored wire that displays exceptional impact properties when used with CO2. The Golden Weld brand produces smoother arc characteristics and lower welding fumes.

Golden Weld 71T-1C was developed to join low and medium carbon steel. Applications include construction, shipbuilding, rail car, and heavy equipment industries.

CONFORMANCES: AWS A5.20 E71T-1C
AWS A5.36 E71T-1-CIA2-CS1

APPROVALS: CE

WELDING PROCESS: FCAW | 100% CO2 Shielding gas



CHEMICAL COMPOSITION

ITEM	%C	%Mn	%Si	%P	%S	%Cr	%Mo	%V	%Cu	%Ni
STANDARD	0.12 max	1.75 max	0.90 max	0.03 max	0.03 max	0.20 max	0.30 max	0.08 max	0.35 max	0.50 max
TEST	0.05	1.6	0.42	0.021	0.006	0.03	0.003	0.02	0.01	0.02

MECHANICAL PROPERTIES

ITEM	Tensile Strength	Yield Strength	Elongation	Charpy V-Notch Impact
	MPa	MPa	%	J@-20 Deg
STANDARD	490 - 660	400 min	22 min	27
TEST	602	541	23	132

OPERATING PROCEDURES

Diameter	1.2mm	1.4mm	1.6mm
F	120 - 300	150 - 400	180 - 450
H-fillet	120 - 300	150 - 300	180 - 400
V-up	120 - 200	150 - 320	180 - 240
H	120 - 280	150 - 320	180 - 350
V-down	200 - 260	220 - 270	230 - 280

PACKAGING

Diameter	Weight
1.2mm	15kg/spool
1.4mm	15kg/spool
1.6mm	15kg/spool

