

FEATURES

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

Conformances: AWS A5.20 E71T-1C, E71T-9C
JIS Z3313 T49J0T1-1CA-U
EN 7632-A T 42 2 P 1

GB T 10045 E501T-1

Approvals: ABS, DNV-GL, LR

Welding Process: FCAW | 100% CO₂ shielding gas

APPLICATIONS

Sheffield Welding 71T-1C/9C is an all-position flux cored wire that displays exceptional impact properties when used with CO₂. The Sheffield brand produces smoother arc characteristics and lower welding fumes. Sheffield Welding 71T-1C/9C was developed to join low and medium carbon steel. Applications include construction, shipbuilding, rail car, and heavy equipment industries.



CHEMICAL COMPOSITION

Element	%C	%Mn	%Si	%P	%S	%Cr	%Mo	%V	%Cu	%Ni
Requirement per AWS A5.20	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
As Welded with 100% CO ₂	0.038	1.25	0.31	0.02	0.003	0.03	0.001	0.05	0.01	0.01

MECHANICAL PROPERTIES

Test	Tensile Strength	Yield Strength	Elongation	Charpy V-Notch Impact	
Requirement per AWS A5.20	MPa 490-670	MPa 390 min	% 22 min	J @-20°C 27 min	J @-30°C 27 min
As Welded with 100% CO ₂	570	510	29	85	54

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	1.2mm (.045)	1.6mm (1/16)
15 kg spool	SW71T-1C1.2x15	SW71T-1C1.6x15
18 kg spool	SW71T-1C1.2x18	SW71T-1C1.6x18
250 kg drum	SW71T-1C1.2x250	SW71T-1C1.6x250

DC+ polarity and 100% CO₂ shielding gas