

Weld 71T-9

WELD 71T-9 is a multipurpose all-position flux cored wire. It has low spatter levels and easy slag removal. WELD 71T-9 can be used with either 100% CO₂ or 75% Ar/25% CO₂. This versatility in gas selection provides the fabricator with flexibility in choosing both wire and gas.

Classifications Weld Metal:	KS D 7104:YFW-C502R/YFL-C503R, SFA/AWS A5.36:E71T1-C1A2-CS1-H8, JIS Z 3313:YFW-C502R/YFL-C503R, SFA/AWS A5.36:E71T1-M21A2-CS1-H8, EN ISO 17632-A:T42 2 P C 1 H10, EN ISO 17632-A:T42 2 P M 1 H10, SFA/AWS A5.20:E71T-1C/1M/9C/9M-H8
Approvals:	ABS 3YSA H10, CWB E491T-9-H8/E491T-9M-H8
Industry or Segmentation:	Civil Construction, Industrial and General Fabrication, Mobile Equipment

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current:	DC+
Alloy Type:	C Mn

Typical Tensile Properties			
Condition	Yield Strength	Tensile Strength	Elongation
100% CO₂			
As Welded	495 MPa (72 ksi)	560 MPa (81 ksi)	31 %
75% Ar - 25% CO₂			
As Welded	580 MPa (84 ksi)	620 MPa (90 ksi)	26 %

Typical Charpy V-Notch Properties		
Condition	Testing Temperature	Impact Value
100% CO₂		
As Welded	-20 °C (-4 °F)	84 J (62 ft-lb)
As Welded	-30 °C (-22 °F)	54 J (40 ft-lb)
75% Ar - 25% CO₂		
As Welded	-20 °C (-4 °F)	90 J (66 ft-lb)
As Welded	-30 °C (-22 °F)	55 J (41 ft-lb)

Typical Weld Metal Analysis %				
C	Mn	Si	S	P
0.038	1.31	0.55	0.007	0.013