



SELF-SHIELDING MILD STEEL FLUX CORED WIRE

E71T-GS

CWB to CSA W48-14
 Classification: E491T14S-AZ-CS3 (E491T-GS)
 AWS/ASME A5.36/A5.36M:2016

Suitable welding positions



Typical applications

Commonly used for home workshop welder, automobile body shop for door or body repairs and it is also used for sheet metal duct work on lap and butt joints.

NOTE: E71T-GS does contain fluoride compounds, so greater attention to proper ventilation is required especially when being used to weld galvanized steel.

Characteristics on usage

- Designed for single pass fillet and lap welding on galvanized or carbon steel
- Can be used on materials as thin as 20 gauge, without burn-through
- Smooth arc action with very little spatter
- Travel speed is fast, penetration is good and easy slag removal
- Commonly used on small portable 110 volt welding machines

Typical chemical composition of all-weld-metal(%)

C	Si	Mn	P	S	Al
0.10	0.12	0.53	0.014	0.006	1.23

Typical mechanical properties of all-weld-metal

Yield Strength		Tensile Strength		Elongation
489 MPa	71 ksi	520 MPa	75 ksi	22%

Dimensions and recommended currents

Vanguard Code & Package Size			Diameter		Amperage (A)		Voltage (V)	
0.9 Kg	4.5 Kg	15 Kg	mm	inches	F & HF	VU & OH	F & HF	VU & OH
6952 0108	6952 0508	—	0.8	0.030	80-120	100-160	16 - 20	15 - 18
6952 0109	6952 0509	—	0.9	0.035	80-120	100-160	16 - 20	15 - 18
6952 0112	6952 0512	69521512	1.2	0.045	140 - 200	120-160	17 - 20	16 - 18
—	—	—	1.6	0.062	180 - 260	160 - 220	19 - 22	17 - 20

Available packaging

Mig Wire 0.09, 4.5 Kg Spools - 0.045" also stocked on 15 Kg Spools
 Not all available packaging are standard stock items