

PRIME WELD

PRIME 71-GS Carbon Steel Flux Cored Wire (Gasless)

CLASSIFICATIONS:
 AWS A5.20: E71T-GS
 AWS A5.36: E71T14S-AZ-CS3
 EN ISO 17632-A: T 42 Z V NO 1
 EN ISO 17632-B: T 49 Z TG-1NOS
 JIS Z3313: T49 TG-1 N S

Purpose: PRIME 71-GS is a self-shield and rutile type flux cored wire for mild and 490MPa high tensile steel application. It features soft arc, less spattering, good portability, suitable for single pass welding, all position welding support. It typically applied for general fabrication, outdoor facilities, thin carbon steel plates, galvanized steel plates etc.

Chemical Composition (%)									
Item	C	Mn	Si	S	P	Ni	Cr	Mo	Al
Standard	0.23	0.5	0.35	0.009	0.010	0.01	0.01	0.01	1.55

Deposited Metal Mechanical Properties (%)			
YIELD STRESS (N/mm ²)	TENSILE STRENGTH (N/mm ²)	ELONGATION (%)	IMPACT VALUES (J)
/	565	/	/

- Self-shielded

SIZES AND RECOMMENDED CURRENT RANGE (DC-)			
DIAMETER Ø	0.8mm	0.9mm	1.2mm
Voltage (V)	10-15	10-16	10-18
Current (A)	100-160	100-200	120-220
Spool (Kg)	1kg/ D100, 5kg/ D200	1kg/ D100, 5kg/ D200	1kg/ D100, 5kg/ D200

WELDING POSITIONS: 

NOTES ON USAGE AND WELDING CONDITION

- The oil stains and rust on the weldments should be cleared away.
- Design for GAS FREE, SELF-SHIELDED (Gasless).
- Use special welding machines for welding with this self-shielding wires.
- Proper storage is recommended when open the packing. 25ℓ/min.