



Smoothcor 71T-GS

Classification:

E71T-GS, E71T-14 per AWS A5.20, SFA 5.20.

Description:

Smoothcor 71T-GS is a carbon steel, flux cored wire for use without an external shielding gas. This flux cored wire is intended for welding thin-gauge carbon steel, ranging from 3/16 " to 22 gauge. Applications are limited to single-pass weldments; this product is designed to weld quite effectively over galvanized material and can be used on certain aluminized surfaces as well. **Smoothcor 71T-GS** requires no external gas- shielding and should be welded with DCEN (straight polarity).

Characteristics:

Smoothcor 71T-GS is a self- shielded, flux cored wire which combines superb welder appeal with exceptional quality and consistency. The arc transfer is smooth and stable, with virtually no spatter emission. This "soft" arc transfer minimizes burn-through on thin gauge material, making the welder's job much easier. This slag system enables the electrode to weld in all positions and also to make welds at high speed. Availability of diameters down to .030" makes this product a fine choice for use on the popular 110 volt power sources. Advanced manufacturing techniques ensure the highest levels of quality, consistency, and performance.

Applications:

The many positive characteristics of **Smoothcor 71T-GS** make it the natural choice for applications such as lap and butt welds on galvanized sheet metal, repair of automobile sheet metal, welding ductwork, and joining of galvanized roofing sheet metal. This flux cored wire is a natural choice for high speed welds on sheet metal up to 3/16" thick, especially galvanized, aluminized, or other coated steels. The small diameters of this product are ideal for the "hobbyist" welder, as they work very well on the small 110 volt power source/feeders, which have become so popular. The ability to weld without a shielding gas enhances the versatility and portability of this electrode.

Typical Mechanical Properties:

Transverse Tensile Strength (psi): 86,400 (Base metal fracture)
Longitudinal Guided Bend Test: Satisfactory

Recommended Welding Parameters (use DCEN):

Optimum

Dia. (in)	Welding Position	Amps	Wire Feed Speed	Volts	ESO (in.)
.030"	V-up, OH	100	170	15	3/8-1/2"
.030"	Flat, Hor.	125	215	15	3/8-1/2"
.035"	V-up, OH	125	160	17	3/8-1/2"
.035"	Flat, Hor.	170	225	16	3/8-1/2 "
.045"	V-up, OH	170	155	17	3/8-3/4"
.045"	Flat, Hor.	200	190	17	3/8-3/4"
1/16"	V-up, OH	170	90	16	1/2-3/4"
1/16"	Flat, Hor.	250	110	18	1/2-3/4"

Notice: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for use in the field. The manufacturer disclaims any warranty of merchantability or fitness for any particular purpose with respect to its products.