



Smoothcor™ 71T-1/T-9

Specifications: AWS A5.20 /ASME SFA5.20 Class E71T-1C H8, E71T-1M H8, E71T-9C H8, E71T-9M H8

Description: Smoothcor™ E71T-1/T-9 is general purpose, all position, flux cored, mild steel, gas shielded wire, used for single and multiple pass welding of carbon steels. Features include fast freeze slag system, good bead appearance and slag removal, a smooth and stable arc with low spatters. It is used in general applications including shipbuilding, offshore structures, bridges and machinery.

Recommended shielding gas: 100% CO₂ and ~75% Argon/25% CO₂. 31-53 cfh - DCEP (DC+)

Typical Chemistry (Chem-Pad)

Product	C	Si	Mn	P	S
AWS/ASME (max.)	.12	.90	1.75	.03	.03
100% CO ₂	.04	.38	1.2	.01	.007
75%Ar/25% CO ₂	.04	.51	1.43	.009	.007

Typical Mechanical Properties (As welded)

	AWS/ASME	100% CO ₂	75%Ar/25% CO ₂
Tensile Strength (psi)	70,000-95,000	91,000	95,000
Yield Strength (psi)	58,000 min.	80,000	86,000
Elongation % in 2"	22 min	29	27

Typical Charpy V-Notch Impact Values (As welded)

CVN Impact Energy	AWS/ASME	100% CO ₂	75%Ar/25% CO ₂
Avg. 20 ft•lbs @ 0°F (-20°C)	20 ft•lbs (27 J) min	65 ft•lbs (88 J)	51 ft•lbs (69 J)
Avg. 20 ft•lbs @ -20°F (-30°C)	20 ft•lbs (27 J) min	51 ft•lbs (69 J)	37 ft•lbs (50 J)

Recommended Welding Parameters

Diameter	Amps	Volts	Wire Feed Speed	Deposition Rate lbs/hr.	Contact Tip Work Distance
.045"	180	24-27	190	6.0	5/8"-3/4"
	200	25-28	240	6.3	
	240	26-30	280	8.0	
	260	27-31	300	8.9	
	300	29-32	340	12.5	
.052"	180	23-26	200	5.3	5/8"-3/4"
	220	24-27	220	6.4	
	260	25-28	250	8.1	
	300	26-29	280	9.4	
	330	27-32	300	13.2	
1/16"	200	23-26	200	5.0	5/8"-3/4"
	240	24-27	220	6.3	
	280	26-29	240	9.4	
	320	27-30	270	11.1	
	320	27-30	270	11.1	
	360	28-31	320	12.2	

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.