

VALIANT

Valiant Core 71 T1

AWS SFA : A 5.20 E 71 T -1C

Valiant Core 71 T1 is a superior quality Flux Cored Wire suitable for welding in all position on wide range of welding current CO2 shielding. The wire is further characterised by smooth arc, easy slag detachability and produces X-ray quality weld with exceptional impact strength at sub-zero temperature down to -20°C.

CHEMICAL COMPOSITION

C	Mn	Si	S	P
0.12 - Max	1.75 - Max	0.90 - Max	0.030 - Max	0.030 - Max

MECHANICAL PROPERTIES

UTS (Kg/mm ²)	YS (Kg/mm ²)	EI (L = 4D)%	CVN Impact strength at 20°C
490 -670	390.0 MIN	22.0 MIN	27.0 MIN

WELDING PARAMETERS

Size (mm)	Flat		Vertical Up		Over Head	
	Voltage V	Current A	Voltage V	Current A	Voltage V	Current A
1.20	22-28	180-300	22-26	150-260	23-26	150-250
1.60	24-30	200-400	20-28	180-280	22-28	180-300

APPLICATION

Valiant Core 71 T1 is recommended for single and multi pass welding of mild steel and carbon steel, typical applications are storage vessels, ship building, earth moving equipment, piping, heavy machinery, bridges, towers, structural fabrication, vehicles and chemical plant etc.

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