

Creating the best welding experience



**BIS Approved**  
**Automig FC 71T-1**  
E71T-1C

# Automig FC 71T-1

AWS A/SFA 5.20 E71T-1C

FCAW C-Mn STEEL

## CLASSIFICATION:

EN ISO 17632 A

T 42 2 R C/M 2

T 42 2 P C1 2

IS 15769

ET531RC-9

## KEY FEATURES:

- Rutile type gas shielded FCW wire
- Low fumes, Minimal spatters with high deposition rate
- Easy slag removal, smooth weld bead
- Suitable for high quality single and multi pass welds
- All position capability
- Radiographic quality weld

**APPROVALS:** BIS/ABS/BV/DNV/LRA/IRS/IBR/CWB/CE

## TYPICAL APPLICATIONS:

- Welding of C-Mn steel with tensile strength up to 500 Mpa
- Bridges, Shipbuilding, Towers, Cranes
- Chemical plant machinery, Hulls
- Storage tanks, Structural steel
- Construction equipment, Farm machinery, Rolling stocks
- General carbon steel fabrication


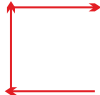
## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si
0.06	1.4	0.4

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact, J at -20°C
Typical	As Welded	570	480	26	60
Specification		490 min	390 min	22 min	47 min

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 1.2 1.6	<b>Amperage, A</b> 130-300 200-380	 <b>DCEP</b>  Use 1-2 volts lower when using mix shielding gas.	All Positions, except vertical down 
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Available in Vacuum Pack of 15 kg wire layer wounded on Plastic Spool

## EQUIVALENT:

GMAW	GTAW	SMAW	SAW	
			Flux	Wire
Automig I	Tigfil 70 S - 2	Supabase X Plus		
	Tigfil 70 S - 6	Supabase	Automelt B71	Automelt EM12K