

GFC 71

FLUX CORED WIRE

CLASSIFICATION:

AWS/SFA 5.36: E71T1-C1A2-CS1
 AWS/SFA 5.20: E71T-1CJ/MJ
 EN 758: T46 0 P C 1 H5 ASME- IIC/SFA-5.20-AWS E71T-1CJ/MJ
 EN ISO 17632 B: T492T1-1CAH5
 BS EN ISO 17632:2015

CHARACTERISTICS:

Tubular Rutile flux-cored wire for single or multi-pass welding of carbon, carbon-manganese steels and similar types of steels, including fine grain ones, with CO₂ shielding gas. This gives good weldability in all positions, excellent bead appearance, less spatter, a fast freezing and easy to remove slag. Deposited welds arc of radiographic quality.

TYPICAL APPLICATIONS:

Power Plant equipments, Off-Shore Platforms, Pressure Vessels, Ship building, Railways Wagons, General Fabrication welding, Pipe welding, Bridges, Automobile parts, Tanks etc.

UNALLOYED STRUCTURAL STEEL:

St 32, St 37-2 to St 52-3, ASME/ASTM SA-516-Grade 60/65/70. IS 2062 or equivalent.

WELD METAL ANALYSIS (RANGE) %:

| C | Mn | Si | S | P |
|-----------|-----------|-----------|-----------|-----------|
| 0.04-0.10 | 0.90-1.50 | 0.30-0.65 | 0.030 max | 0.030 max |

MECHANICAL PROPERTIES (RANGE):

| UTS (MPa) | YS (MPa) | ELN (%) (L=4D) | CVN Impact strength | |
|-----------|----------|----------------|---------------------|--------|
| | | | Temp | Joules |
| 510 min | 440 min | 22 min | -20°C | 90J |

SHIELDING GAS: CO₂ or 80% Argon + 20% Co₂ (M)

FLOW RATE: 14-20 l/min

RECOMMENDED WELDING PARAMETERS :

| Size (mm) | Amps DC (+) | Voltage (V) | Weight of the spool (KG) |
|-----------|-------------|-------------|--------------------------|
| 1.2 | 200-400 | 22-35 | 15 |
| 1.6 | 200-400 | 23-37 | 15 |

Welding Position:



Manufactured by: GEE LIMITED

Regd. Off & Works: plot No.B - 12, MIDC, Kalyan-Bhiwandi Road, Saravli, Kalyan (West) Thane, Maharashtra, India.
 Website: www.geelimited.com

Authorised Distributor: CROSS MARKETING

Head Office: Martin Burn Business Park | Suite No 900A | Block- BP | Salt Lake | Sector - V | Kolkata - 700091 | West Bengal | India
 Ph: (+91) 9163763419 | (+91) 9038320189
 Email: lakhotia.ravi@gmail.com | crossmarketingkolkata@gmail.com

<https://crossmarketing.co.in>