

Dual Core 71 R

Rutile CORED/FCAW

Standards

EN/ISO-Standard - 17632-A

AWS-Standard - A5.20

EN/ISO-Classification - T 46 4 (2) P M21 (C1) 1 H5

AWS-Classification - E71T-1M (C1) J H4

Features and Applications

- Seamless rutile flux cored wire with rapidly solidifying slag.
- Excellent welding properties combined with extreme impact toughness down to -40°C.
- The wire is all positional and runs with a very stable soft arc producing excellent weld bead finish with negligible spatter.
- Ideal for root welding on ceramic backing.
- Due to the seamless technology the typical diffusible hydrogen content is <3.0 ml 100 g
- Test certificates supplied as 3.1 which is actual weld chemistry + mechanicals according EN 10204:2004.
- Precision layer wound for superior wire feeding characteristics.
- Typically used on steel structures, pipelines, shipbuilding, non-alloy and fine grain steels, pressure vessels, offshore, mechanical engineering, heavy transport and general fabrication etc.
- **Test Certificates can be found online @wilkinsonstar247.com**



Optional Plastic Alignment Hole Clip
Order Code: BS300-CLIP

Typical Base Materials

Steel type	EN
Shipbuilding steels	A, B, D, AH 32 - EH 36
Unalloyed structural steels	S185 - S355
Boiler steels	P235GH - P355GH
Pipe steels	P235T1/T2 - P460NL2
Fine grain steels	S235 - S460QL1
Steel acc. API-standard	X42 - X60

* Illustrative, not exhaustive list

Welding Positions

EN ISO 6947 - PA, PB, PC, PD, PE, PF, PG

Shielding Gases

EN ISO 14175 - C1, M21

Polarity

DC (+)

Welding Parameters

Ø mm	1.20
Current (A)	160-280
Voltage (V)	21-29

Mechanical Properties

Tensile Strength (N/mm ²)	Yield Strength (N/mm ²)	Elongation (%)	Impact Strength (J)	Test Temperature
600	530	26	100	-20°C
			70	-40°C

Mechanical properties are approximate and may vary based on the heat, shielding gas, welding parameters and other factors.

Chemical Composition % (Typical)

C %	Si %	Mn %	P %	S %	Cr %	Ni %	Mo %	Cu % ^a	Al %	V %	Ti %	Nb %
0.03	0.41	1.29	0.012	0.006	0.030	0.013	0.004	0.145	0.002	0.020	0.044	0.05

a (Includes copper coating)

Packaging Data

Part No.	Diameter Ø (mm)	Package Weight (Kg)	Package Type	Pallet Quantity
3010500339	1.20	16	BS300 PLW	64

Drums also available.

Liability: Whilst all reasonable efforts have been made to ensure the accuracy of the information contained, this information is subject to change without notice and can be only considered as suitable for general guidance.

