

## Classification

<b>AWS A5.36</b>	<b>EN ISO 17632-A</b>
E71T1-C1A0-CS1-H8	T42 2 P C 1 H10

## Characteristics and typical fields of application

BOHLER Ti 71-T1C is a rutile flux cored wire with fast freezing slag. Excellent welding characteristics in all positions, using 100% CO<sub>2</sub> gas. Very good mechanical properties, easy slag removability, low spatter level, smooth and well shaped beads with X-ray-quality. Applicable in out-of-position welding, with higher productivity and less time for postweld cleaning.

Suitable for butt and fillet welding of hulls, storage tanks, mechanical and constructional steel structure and bridge.

## Base Materials

S 235JR, S275JR, S355JR (st 33, st37-2, st44-2, st52-3), S355J2, P235 GH, P265GH, API 5L X42 -X 60, AH 32, EH-36, A 40-F40, SA 516- Gr60, Gr65 ...etc

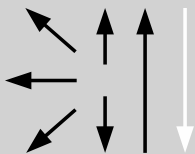
## Typical analysis of all weld metal (wt.-%)

C	Si	Mn	P	S
Max. 0.12	Max. 0.90	Max. 1.75	Max. 0.03	Max. 0.03

## Mechanical properties of all-weld metal

Heat treatment	Yield strength R <sub>e</sub> N/mm <sup>2</sup>	Tensile strength R <sub>m</sub> N/mm <sup>2</sup>	Elongation (L <sub>0</sub> =5d <sub>0</sub> )	Impact work ISO-V KV J
	MPa	MPa	%	- 20°C
As Welded	≥ 400	490 – 660	≥ 22	≥ 47

## Operating data



**Polarity**  
+ / DCEP

**Shielding Gas** : 100% CO<sub>2</sub>  
**Interpass temperature**: Max. 200°C

## Approvals

ABS, DNV-GL (0.045", 1.2 and 1.6 mm), LR (1.2 and 1.6 mm), BKI (1.2 mm)

## Size, Packaging and Electrical Operating Data

Size mm	Kg / Spool		Amperage (A)
	Type S200	Type S270/S300	
1.14 (0.045")	5.0	15.0	120 – 280
1.2	5.0	15.0	120 – 280
1.6	5.0	15.0	230 – 450