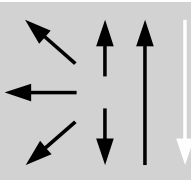


Classification						
AWS A5.20			AWS A5.36			
E71T-8-JH8			E71T8-A4-CS3-H8			
Characteristics and typical fields of application						
<p>BOHLER Ti 71-T8 is a self-shielded flux cored wire designed for all-position welding with excellent CVN impact properties in as welded condition at - 30°C, suitable for butt, fillet welding of 490Mpa steel and low temperature steel of structure such as structural steel, buildings and storage tanks, etc.</p> <p>The wire exhibits good penetration, good moisture index, low spatter level, easy slag removability and fast deposition rate. The weld metal shows very good mechanical properties, smooth and good weld beads with X-ray-quality.</p> <p>It is suitable for outdoor welding, such as structural work, steel frame and building construction.</p>						
Base Materials						
S235JR, S275JR, S355JR, P235 GH, P265GH, API 5L X42 -X 60, AH 32, EH-36, A 40-F40, SA 516- Gr60, Gr65						
Typical analysis of all weld metal (wt. - %)						
	C	Si	Mn	P	S	Al
Wt.-%	0.15	0.20	0.60	0.010	0.009	0.60
Mechanical properties of all-weld metal						
Condition	Yield strength R _e N/mm ²	Tensile strength R _m N/mm ²	Elongation (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	- 30°C		
u	400	490 – 660	≥ 22	≥ 27		
u untreated, as welded – no shielding gas						
Operating data						
		Polarity DC (-)	Shielding gas: No gas	Ø (mm) 1.6 2.0		
Approvals						
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