

Classifications

AWS A5.20 / SFA-A5.20
EN ISO 17632-A

E71T-1C-H8/ E71T-9C-H8

T 42 3 P C1 1 H10

Characteristics and typical fields of application

BÖHLER Q 71.1 RC (C1) is a rutile flux cored wire with fast freezing slag. Excellent welding characteristics in all positions, using pure CO₂ as shielding gas. Very good mechanical properties, easy slag removability, low spatter level, smooth and well shaped beads. Applicable in out-of-position welding, with higher productivity and less time for post weld cleaning.

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

Base materials

S235JR, S275JR, S355JR, P235 GH, P265GH, API 5L X42 -X 60, AH 32, EH-36, A 40-F40, SA516- Gr60, Gr65

Typical analysis

	Gas	C	Si	Mn
wt.-%	C1	0.058	0.37	1.25

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength R _e	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact energy ISO-V KV J
	MPa	MPa	%	
u	470 (≥ 420)	540 (500-640)	27 (≥ 22)	85 (≥ 47)

u untreated, as welded – shielding gas C1

Operating data

	Polarity	DC+	Dimension mm
	Shielding gas	C1	1.2
	(EN ISO 14175)		1.6

Welding with standard GMAW-facilities possible

Approvals

ABS, DNV, LR, BKI, BV