



# FALCON Series Falcon E71T-1C

FALCON series Falcon E71T-1C is a cost-effective quality flux cored wire designed for all-positions welding with 100% CO<sub>2</sub> shielding. This wire offers optimum welding performance under soft and stable arc with less fume and spattering. Produce smooth bright and flat weld bead with easy slag removal.

## Classifications

AWS A5.20 E71T-1C  
 AWS A5.20M E491T-1C  
 ISO 17632-A: T42 2 P C1 1  
 ISO 17632-B: T49 2 T1-1 C1 A

## Typical all weld metal composition, wt. %

	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	≤0.12	≤1.75	≤0.90	≤0.20	≤0.50	≤0.30	≤0.03	≤0.03	≤0.08
Typical	0.045	1.52	0.530	0.02	0.02	0.030	0.022	0.018	0.020

## Mechanical properties of all well metal

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V (J/°C)
AWS	as welded	390	490-670	22	27J/-20°C
Typical	as welded	495	570	27	80J/-20°C

## Operating Parameters

Polarity	Shielding	Current (A)	Voltage (V)	Gas flow
DCEP	100% CO <sub>2</sub>	150-300 (1.2mm)	23-32 (1.2mm)	20-25 L/min (1.2mm)
		200-400 (1.6mm)	24-36 (1.6mm)	20-25 L/min (1.6mm)

## Packing & Ordering Information

Wire sizes	Carton Weight	Pallet Weight	Packing method
1.2mm 1.6mm	15kg	1,080kg	Vacuum packed

- Proper wind-shielding measures are advisable to avoid porosity.
- Increase voltage by 1-2V, when welding cable are more than 15 meter long.
- Ensure base materials are free from moisture, dust, rust and oil before welding.

A Quality Product of

