

Tru-Core® FC 71T-12C Flux-Cored Welding Wire

AWS E71T-1C H8, E71T-9C H8, E71T-12C H8



Tru-Core® FC 71T-12C is a flux-cored, gas-shielded, all-position electrode designed specifically for use with 100% CO₂ shielding gas. It is intended for single and multiple pass applications, for both in-position and out-of-position welding. The metal transfer in the arc is small-droplet in nature, resulting in a smoother arc and lower spatter levels when compared with other E71T-9C, -12C electrodes.

The slag characteristics allow for both fast freezing and good coverage of the weld, which produces a flatter, more uniform bead geometry in all position welds. Microalloying of the weld metal provides enhanced CVN impact values.

100% Made in the U.S.A. with American steel to meet "Buy America" Standards.

Manufacturing Advantages

- Welding most carbon steels and certain low alloy steels
- Ideal for welding thicknesses varying from 10-gauge sheet metal to heavy plate sections
- Patented forming, feeding, and drawing equipment
- Consistent strip-to-core ratio
- Precise thermal treatment that controls the type, amount, and uniformity of surface oxides on the wire
- Consistent diffusible hydrogen levels

Welding Positions

All position welding is possible when using the correct shielding gas blends, welding process, and welding parameters.

Shielding Gas Blends

- 100% CO₂
- Flow rate: 35-45 CFH

Applications

- Agricultural Equipment
- General Fabrication
- Heavy Equipment
- Pipe Welding
- Pressure Vessels
- Structural Steel
- Trailers

Specifications

Meets or Exceeds:

- AWS A5.20: E71T-1C H8, E71T-1C H8, E71T-9C H8, E71T-12C H8
- ASME SFA-A5.20: E71T-1C H8, E71T-9C H8, E71T-12C H8

✓ Made in the USA

Storage

Welding wire should be stored in a dry, enclosed environment and in its originally sealed package.



3602 North Perkins Road
Stillwater, OK 74075
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www.NSARC.com



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Typical Weld Metal Composition (as required per AWS)

	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
100% CO ₂	0.04	1.36	0.36	0.007	0.009	0.06	0.42	0.04	0.001	0.02
AWS/ASME	0.12 (max.)	1.6 (max.)	0.90 (max.)	0.03 (max.)	0.030 (max.)	0.35 (max.)	0.50 (max.)	0.20 (max.)	0.30 (max.)	0.08 (max.)

Typical Mechanical Properties (as welded)

	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION (% IN 2")	CVN @ -20° F (-29°C)
100% CO ₂	84.3	75.8	30	71.3 ft-lbf
AWS/ASME	70-90	58 (min.)	22 (min.)	20 ft-lbf

Typical Diffusible Hydrogen (ml/100g)

100% CO ₂	3.4
AWS A4.3	4.0 (max.)



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