

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

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



Tru-Core® FC 71T-12M is a flux-cored, gas-shielded, all-position electrode, designed specifically for use with gas mixtures from 75% to 80% Argon/balance CO₂. It is intended for single and multiple pass applications for both in-position and out-of-position welding.

Up to 80% Argon can be used with no degradation in welding performance or mechanical properties. The arc transfer is small-droplet in nature with no appreciable spatter. The slag is fluid enough to provide good flow and wetting but freezes quickly, promoting flat, uniform bead shapes in all positions. Microalloying of the weld metal enhances CVN impact values at lower temperatures.

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

- 75-80% Argon/Balance 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-1M H8, E71T-9M H8, E71T-12M H8
- ASME SFA-A5.20: E71T-1M H8, E71T-9M H8, E71T-12M H8

✓ Made in the USA

Storage

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

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Typical Weld Metal Composition (as required per AWS)

	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
75% Ar/25% CO ₂	0.05	1.35	0.32	0.011	0.007	0.06	0.39	0.05	0.01	0.019
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)
75% Ar/25% CO ₂	83.5	72.6	29	79.6 ft-lbf
AWS/ASME	70-90	58 (min.)	22 (min.)	20 ft-lbf

Typical Diffusible Hydrogen (ml/100g)

75% Ar/25% CO ₂	2.74
AWS A4.3	4.0 (max.)



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