

Tru-Core® FC 71T-AG Flux-Cored Welding Wire

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



Tru-Core® FC 71T-AG is a gas-shielded, all-position electrode for use with E71T-1M H8 and E71T-9M H8 wire. The arc transfer of Tru-Core® FC 71T-AG welding wire is characterized by small-droplet nature, ensuring a smooth and spatter-free welding process.

The fluid slag composition allows for excellent flow and wetting, while its fast-freezing properties promote the formation of flat and uniform bead shapes in all positions. The microalloying of the weld metal enhances CVN impact values, particularly at lower temperatures. Up to 80% Argon can be used with no degradation in welding performance or mechanical properties.

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

Manufacturing Advantages

- Welds 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
- CWB W48: E9491T1-M21A3-CS1-H8 (E491T-9M-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
Customer Service: 1-800-777-1618
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
75% Ar/25% CO ₂	0.04	1.38	0.43	0.009	0.007	0.06	0.02	0.06	0.01	0.016
AWS/ASME	0.12 (max.)	1.75 (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	84.2	74.1	28	62.6 ft-lbf
AWS/ASME	70-95	58 (min.)	22 (min.)	20 ft-lbf

Typical Diffusible Hydrogen (ml/100g)

75% Ar/25% CO ₂	2
AWS A4.3	4.0 (max.)



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