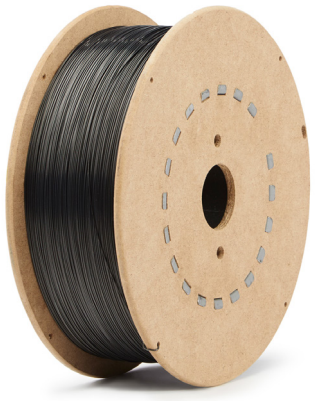
Tru-Core® FC 71T-CG Flux-Cored Welding Wire

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



Tru-Core® FC 71T-CG is a flux-cored, gas-shielded, all-position electrode, designed specifically for use with 100% CO_2 shielding gas. The small-droplet metal transfer in the arc creates a smoother arc and reduces spatter levels compared to other E71T-1C and -9C electrodes.

The slag characteristics of Tru-Core® FC 71T-CG enable better flow and wetting of the weld, resulting in a flatter and more uniform bead geometry across all positions. With microalloying of the weld metal, it enhances CVN impact values for superior strength and durability.

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% CO_2
- 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-9C H8
- ASME SFA-A5.20: E71T-1C H8, E71T-9C H8
- Made in the USA

Storage

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

NS ARC National Standard

3602 North Perkins Road
Stillwater, OK 74075
Customer Service: 1-800-777-1618
www.NSARC.com

NS NATIONAL-ARC® TRU-CORE® National Standard

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MANUFACTURED BY AN ISO 9001 CERTIFIED COMPANY

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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	0.05	1.38	0.35	0.01	0.007	0.06	0.48	0.05	0	0.014
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)
100% CO_2	80.5	69.1	33	59.6 ft-lbf
AWS/ASME	**70-95**	**58 (min.)**	**22 (min.)**	**20 ft-lbf**

Typical Diffusable Hydrogen (ml/100g)

100% CO_2	3.2
AWS A4.3	**4.0 (max.)**

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