

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

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



The Tru-Core® FC 71T is a flux cored, gas shielded, all-position electrode intended to weld carbon steel, as well as certain low alloy steels, where a minimum tensile strength of 70,000 psi is required. It is intended for single and multiple pass welding using 100% CO₂ or 75-80% Argon/balance CO₂ mixtures.

Major advantages of this electrode include deep penetration, smooth stable arc transfer, low spatter levels, and a slag system specially formulated for a high melting point. This provides a very quick-freezing slag.

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

Manufacturing Advantages

- Welding most carbon steel and certain low alloy steels
- Ideal for welding gauges 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
- 75% Argon/25% 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-1M H8, E71T-9C H8, E71T-9M H8
- ASME SFA-A5.20: E71T-1C H8, E71T-1M H8, E71T-9C H8, E71T-9M H8
- CWB W48: E491Ta-M21A3-CS1-H8 (E491T-9M-H8)
- ABS

 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
100% CO ₂	0.04	1.54	0.41	0.01	0.008	0.06	0.02	0.06	0.01	0.016
75% Ar/25% CO ₂	0.05	1.41	0.45	0.009	0.01	0.06	0.02	0.03	0.002	0.017
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.)	0.20 (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	83.6	72.7	29	54.3 ft-lbf
75% Ar/25% CO ₂	80.8	68.4	29	41.6 ft-lbf
AWS/ASME	70-95	58 (min.)	22 (min.)	20 ft-lbf

Typical Diffusible Hydrogen (ml/100g)

100% CO ₂	2.2
75% Ar/25% CO ₂	3.2
AWS A4.3	4.0 (max.)



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