

# FabStar 71

AWS A5.20 E71T-1C  
EN ISO 17632-A-T 46 2 P C1 1 H10  
JIS Z 3313 T49J 0 T1-1 C A-U

## Characteristics and Applications:

FabStar 71 is designed for the mild steel and 490N / mm<sup>2</sup> high-tension steel with the gas shield coating line. Welding operation is good, less dust, arc soft and stable. Especially in the horizontal fillet welding and docking position, the weld bead is formation, welding slag are thin and easy to remove with melt filling high efficiency, and anti-cracking and X-ray detection performance is excellent, which particularly suitable for steel and lifting industry welding.

## Notes on Usage:

1. With DC positive electrode DC + (wire bonding) welding.
2. The use of CO<sub>2</sub> for the protection of gas purity to be more than 99.8%.
3. Transport and storage should pay attention to moisture.

## Typical chemical composition of weld metal (wt%)

	C	Mn	Si	P	S
AWS	≤0.12	≤1.75	≤0.90	≤0.03	≤0.03
EN ISO	-	≤2.0	-	-	-
Typical value	0.05	1.34	0.45	0.017	0.005

## Typical mechanical properties of weld metal :

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-1bf)	
				-20°C(0°F)	-30°C(-20°F)
AWS	≥390(58)	490-670(70-95)	≥22	≥27(20)	≥27(20)
EN ISO	≥460(67)	530-680(77-99)	≥20	≥47(35)	-
Typical value	530(77)	585(85)	28	70(52)	45(33)

## Welding position



## Sizes and recommended parameter range ( DC <+> ):

Stick out : 15-25 (mm), gas flow rate : 20-25 (l/min)

Position	Diameter (mm)	1.2	1.6
	F, HF		160A~300A / 22V~34V
H		200A~260A / 23V~28V	200A~400A / 28V~42V
VU, OH		140A~220A / 22V~28V	160A~280A / 22V~28V
VD		230A~280A / 28V~33V	250A~320A / 28V~32V

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