

CORDIFF 71 T-1

Features:

- ✓ All-Position Flux-Cored Wire
- ✓ Superior Impact Value Properties
- ✓ Very Low Fume Generation
- ✓ Beautiful Bead Appearance
- ✓ Superb Operator Appeal
- ✓ Spatter-Free Welds
- ✓ Smooth, Stable Arc
- ✓ High Deposition efficiency

Characteristics:

CORDIFF 71T-1 is a general purpose, all-position flux-cored mild steel wire designed to produce superior mechanical properties that exceed the charpy v – notch impact value requirements. A diffusible hydrogen content of less than 5.0ml per 100 grams of deposit. CORDIFF 71T-1 is an outstanding wire produces X-ray quality weld deposits using either 100% CO₂ as shielding gas. CORDIFF 71T-1 has superb welder appeal because its' smooth stable arc virtually spatterless and fast freezing weld deposits and generates very little fume. Position welding is made simple because of the fast freezing, easily removable slag. Weld deposits are flat to slightly convex and have a bright finish.

Applications:

Suitable for welding mild and mild tensile steels material such as St 37-2, St-52-3, St-35.8, St-45.8, and also for welding ship building steels, Bridges, Towers, Vehicles, Rolling stocks, Chemical parts and Machinery, wagons, steel frame etc. Can be used as base layer under hardfacing layers

Classification: SFA/AWS A5.20 – E71T-1C and E71T-1M

DIFFUSION ENGINEERS LIMITED

Regd. Office & Works I : T-5/6, M.I.D.C, Hingna Industrial Area, Nagpur-440 016, (T) 091-7104-232084, 234727 (F) 232085

Works II : N-78/79, MIDC, Hingna Industrial Area, Nagpur – 440 016. (T) 091-7104-236036

Works III : T-12, MIDC, Hingna Industrial Area, Nagpur – 440 016.(T) 091-7104-232984

Email : info@diffusionengineers.com Website : www.diffusionengineers.com

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Typical Chemical Composition:

C	Si	Mn
0.05	0.35	1.28

Mechanical properties:

Tensile Strength	Yield Strength	% Elongation	CVN-Impact value at -20°C
500 – 655 N/mm ²	400 N/ mm ² (min.)	22% (min.)	47 J (min.)

Welding Parameters:**Polarity:** DC + ve**Stick out:** 20 to 25mm**Shielding gas:** 100% CO₂ OR 80%Ar / Balance CO₂**Gas flow:** 15 to 25Ltrs per minute

DIA. (mm)	VOLTAGE	AMPS
1.2	20-26	110-180
1.4	22-28	130-220
1.6	24-30	160-250

STANDARD PACKING:**Spool = 12.5 kgs(± 1kg) Spool = 15 kgs(± 1kg) Spool = 25 kgs(± 1kg)****DIFFUSION ENGINEERS LIMITED**

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