

Classification
AWS A5.20
EN ISO 17632 – A

E71T-1C-H8

T 42 2 PC1 H10

Characteristics and field of use

BOHLER Q 71 RC (C1) is Rutile flux cored wire specially designed for positional welding including out of position welding. Weldability characterized by fast freezing slag, less spatter, fine droplet transfer at low & high welding parameters enables easy slag removal; very less post weld cleaning operation produces X-Ray quality weld deposit.

It gives excellent mechanical properties and is suitable for welding of hulls, storage tanks, bridges, water wall panels, structures and constructional steels.

Base Materials

SA 516-Gr.60, Gr. 65, IS 2062, Gr. A, Gr. B, A 36, SA 106 Gr. B, S 235 JR, S275JR, S355 JR (st33, st37-2, st44-2, st52-3), P235 HG, API 5L X42-60, AH32, EH-36, A40 –F40 etc.

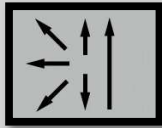
Typical Composition of all weld metal (wt. - %)

C	Si	Mn	S	P
0.04	0.40	1.25	0.015	0.020

Typical Mechanical Properties of all weld metal

Condition	Yield strength R_e N/mm ²	Tensile strength R_m N/mm ²	Elongation ($L_0=5d_0$)	Impact Test Values (J)
	MPa	MPa	%	-20 °C
As welded	490	570	27	90

Operating data

Position	Polarity	Re-drying/baking conditions: NA	Ø(mm)	Amps
	+ / DCEP	Shielding Gas : 100% CO ₂	1.20	120 - 280
Size & Packaging (Vacuum Packed)		Size(mm)	Kg/Spool	
		1.20	15.0	
		1.20	5.0	

Approvals

IRS , ABS and CE (Under Process)