

Seamless Rutile Type Flux Cored Wire **ELCOR R 71 SC**

Standards

TS EN ISO 17632-A : T 46 4 P C1 H5 / T46 4 P M1 H5 : T 46 4 P C1 H5 / T46 4 P M1 H5 EN ISO 17632-A

AWS A5.20 : F71 T-1C/-1M H4

Chemical Composition of Weld Metal (Typical)

С	Si	Mn	
0.05	0.5	1.3	

Mechanical Properties

Heat Treatment	Yield Strength (N/mm²)	Tensile Strength (N/mm²)	Impact S (ISO-V/-20°C) (with M21 gas)	(ISO-V/-40°C)	Elongation ((Lo=5do) (%)
AW	min. 460	530-680	min. 75 J	min. 60 J	min. 22

AW: as welded

Typical Base Material Grades

• S235JR, S275JR, S235J2G3-S355J2G3, P 235T1-P355T1, P235T2-P355T2, L210NB-L360NB, L290MB L415MB, P235G1TH, P255G1TH, P235GH-P355GH, P295GH, S235JRS1-S235J4S, S315G1S-S355G3S, S255N-S380N, S255NL-S355NL, GE200-GE260

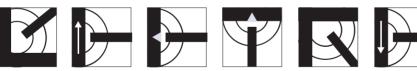
Features and Applications

- Rutile type seamless copper coated flux cored wire which is used for the welding of machinery and welding applications on ship, and steel constructions in all positions.
- Provides high mechanical properties, proper, smooth, X-ray safety seams.
- It is economical as it has high melting ability and can work with high current in all positions.
- Shielding Gas: CO₂ or M21

Welding Positions















Current Type

FCAW / D.C. (+)

Packaging Details

Diam (mm) /		Weight (Kg)	Spool Type
1.20	0.047"	15	BS300