

CORDIFF 71T5

Characteristics:

CORDIFF 71T5 is specially developed basic flux cored wire for all position welding, which gives radiographic weld metal quality with low hydrogen. It gives superior strength and impact properties. Arc is stable. Low spatter loss with easy slag removal. Using 80%Ar/Balance CO₂ or 100% CO₂ as the shielding gas.

Applications:

Suitable for Multipass welding on Structural steels, Boiler quality steels, Pressure vessels, Heat Exchanger, Ship-Building, Bridges and Heavy machinery parts. Heavy earth moving equipments like Bucket Wheel Excavators, Dumpers, Dozers etc.

Classification: SFA/AWS A5.20 – E71T-5C and E71T-5M
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Major Alloying Element :

C	Si	Mn	P	S
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Mechanical Properties:

Tensile Strength	Yield Strength	% Elongation	CVN-Impact value at -30°C
525-655 N/mm ²	415 N/mm ² (min.)	22% (min.)	30 J (min.)

WELDING PARAMETERS :

Polarity: DC + ve

Shielding gas : 100% CO₂ OR 80 %Ar / Balance CO₂

Gas flow : 15 to 25 Ltrs 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

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

Branch Offices : Chennai, Faridabad, Jamshedpur, Pune, Raipur, Secunderabad, Vadodara.