

Supercored 71MAG

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1M/-9M
JIS Z3313 T49 3 T1-1 M A-U H10
EN ISO 17632-A-T 46 3 P M 1

Applications

Building, shipbuilding, bridge construction, machinery, and vehicles.

Characteristics on Usage

Despite welding position, it will get low spatter, soft arc, good bead appearance and excellent weldability with this wire.

Notes on Usage

- ① Proper preheating(50~150°C)(122~302°F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
- ③ Use Ar+20~25% CO₂ gas.

Welding Position



1G 2F 3G 4G
(PA) (PB)(PF.PG)(PE)

Current

DC +

Shielding Gas

Ar + 20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.04	0.54	1.25	0.011	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
580 (84,200)	600 (87,100)	28	-30 (-22)	60 (44)

Approval

ABS, LR, BV, DNV, GL, TÜV,
CE, DB, RINA, CWB

I Packing(Including Ball Pac)

Dia. (mm) 1.0 1.2 1.4 1.6
(in) .039 .045 .052 1/16

Spool(kg) 12.5 15 20
(lbs) 28 33 44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	220~290	240~320	260~350
V-up, OH	180~250	200~260	230~290
V-down	210~290	250~320	270~330