

Data Sheet

Flux cored wire

 Materials Services
 Materials Ibérica

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Designation	Name	Material No.
TKM E71T-1M H5	E71T-1M	

Approvals

EN ISO 17632-A:	T46 3 P M21 1 H5
AWS A 5.20:	E71T-1M



Characteristics and Applications:

TI E71T-1M H10 is a flux cored wire designed to be used with Ar/CO² gas. It is available for all positions welding with both single and multiple pass welds on mild and 490 N/mm² high tensile steels. It features good impact properties, less fume, stable arc, easy slag removable and excellent X-Ray inspection. Typical applications include shipbuilding, storage vessels, structural fabrication, machinery and piping etc.

Typical chemical composition of weld metal (wt%):

	C	Mn	Si	P	S	Cu	Ni	Cr	Mo	V
Specification	≤0.12	≤1.75	≤0.90	≤0.030	≤0.030	≤0.35	≤0.50	≤0.20	≤0.30	≤0.08
M21	0.043	1.28	0.47	0.012	0.009	0.023	0.012	0.023	0.011	0.010
100% CO ²	0.043	1.28	0.47	0.012	0.009	0.023	0.012	0.023	0.011	0.010

Typical mechanical properties of weld metal:

	Deposit Metal Mechanical Properties					Welding Parameter			
	Tensile Strength MPa	Yield Strength MPa	Elongation (%)	Absorbed Energy A%	Mercury diffusion hydrogen content	Type of current	Ampere	Voltage	Shielding Gas
Requirement	530-680	≥460	≥20	≥27 (-40°C)	≤5	DCEP	150-300A	23-30V	M21 100% CO ²
M21	607	530	26.0	110/107/106	4.27/44.31/4.25				
100% CO ²	555	485	27.5	100/93/105					

Editor

thyssenkrupp Materials Ibérica, S.A.
Pol. Ind. de Martorelles
C/ Sant Martí s/n
08107 Martorelles - Barcelona
España



thyssenkrupp