

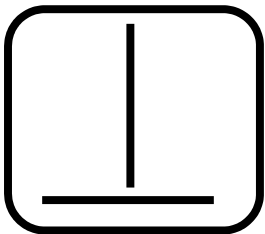
CHARACTERISTICS :-

Fine 71 is a Rutile type Co₂ gas shielded flux cored welding wire. It Provides excellent performance in welding: slag easy to remove, low spatters, stable arc & bead appearance is good. The wire is suitable for all position welding.

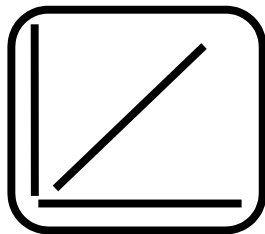
APPLICATION :-

Welding of mild steels and carbon steels with specified tensile strength up to 500 N/mm² for fabrication of machinery, structure, steel frames, ships, Boilers, Pressure Vessel, Auto Parts, Bridges & Chemical Plant etc.

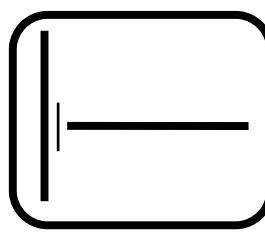
WELDING POSITION :-



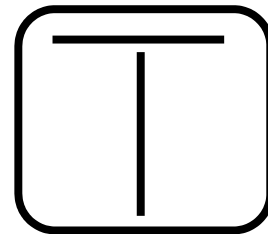
1G



2F



3G



4G

CHEMICAL COMPOSITION OF WELD METAL

Element	C%	Mn%	Si%	S%	P%
Typical Values	0.05	1.25	0.38	0.010	0.018
Spec. Reqd.	0.12 Max	1.75 Max	0.90 Max	0.03 Max	0.03 Max

MECHANICAL PROPERTIES OF WELD METAL

Property	U.T.S. (N/mm ²)	Y.S.(N/mm ²)	ELONGATION(L = 4d)%	CVN IMPACT AT - 20°C (J)
Typical Values	550	470	26	60
Spec. Reqd.	490 - 670	390 Min	22 Min	27 Min

WELDING PARAMETERS (DC + VE): -

Diameter (mm)	Flat & Horizontal(A)	Flat & Horizontal(V)	Vertical-UP (A)	Vertical-UP (V)	Overhead (A)	Overhead (V)
1.20	180 - 250	26 - 30	120-210	22 - 26	150 - 200	26 - 30
1.60	210 - 280	26 - 30	160-250	22 - 27	190 - 240	26 - 30

Packing : - 15 kgs. Spool Vacuum Packed