

Dual Shield 7000-A1

AWS A5.29 E81T1-A1C / JIS Z3318 YFM-C

Description and Application

- Dual Shield 7000-A1 is an all-position flux cored electrode recommended for 0.5% Mo steels. It is used in the fabrication and erection of boilers, pressure piping and tubing and other pressure vessel applications. Shielding gas of 100% CO₂ and 75% Ar, remainder CO₂ may be used. 75% Ar/25% CO₂ shielding gas mixture is recommended to improve arc characteristics, increase wetting action, decrease penetration, and provide easier arc control for out-of-position welding. The weld metal analysis is similar to an E7018-A1 low hydrogen electrode.

Flux
CORED
WIRES

Shielding Gas : 100%CO₂ or 75%Ar/25%CO₂

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	PWHT
560 {57}	630 {64}	23	As-Welded
540 {55}	610 {62}	26	620 °C x 1hr

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	Mo
0.05	1.02	0.57	0.51