

# Dual Shield 7100 Ultra

AWS A5.20 E71T-1C/1M/9C-J/9M / JIS Z3313 T492 T1-1CAP-U

Flux  
CORED  
WIRES

## Description and Application :

- Dual Shield 7100 Ultra is an all-position flux cored electrode designed for optimum performance when using 100% CO<sub>2</sub> shielding but works well 75% Argon/25% CO<sub>2</sub> and 80% Argon/20% CO<sub>2</sub> Mixes. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads.
- Fillet contour is flat slightly convex with equal leg lengths and uniform sidewall welling. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness.

## Shielding Gas : 100%CO<sub>2</sub> or Argon/CO<sub>2</sub>

## Application

- Dual Shield 7100 Ultra has been designed for general purpose use but has particular applications in shipyard welding where high efficiency and versatile operation are most important. It may be used in a variety of other applications including railcar, automotive, heavy equipment, and general structural steel fabrication. It is especially recommended in applications where reduction of welding fume is important.

## Typical Mechanical Properties of All Weld Metal

Yield Point N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Tensile Strength N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	Elongation (%)	Impact Value J(kgf · m)		PWHT
			-20°C	-30°C	
520 {53}	580 {59}	28	127 {13.0}	85 {8.6}	As-Welded
500 {51}	560 {57}	30	116 {11.9}	66 {6.7}	620°C x8hr

## Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S
0.04	1.35	0.57	0.013	0.005

## Approvals

ABS, LR, DNV, BV, GL, NK, KR, CCS, TUV, JIS