

Dual Shield 7100-W

JIS Z3320 YFA-50W

Description

- Dual Shield 7100W is an all-position electrode developed specifically to meet the demand for weld deposits that color match the low alloy, high strength weathering grade steels.
- Dual Shield 7100W is a smooth arc action, attractive weld appearance, easily removed slag, and low spatter.
- This electrode displays good operator appeal and produces high strength deposits. It is an ideal choice for structural applications where the architectural “weathering look” is of importance.

Shielding Gas : 100%CO₂

Application

- Dual Shield 7100W is designed to operate in the flat, vertical and overhead positions. It is intended for use on low alloy weathering grade steels such as A588, A242, Cor-Ten® and Mayari R®. This electrode is designed to be shielded with CO₂ gas only.

Typical Mechanical Properties of All Weld Metal

Yield Point N/mm ² {kgf/mm ² }	Tensile Strength N/mm ² {kgf/mm ² }	Elongation (%)	Impact Value J(kgf · m)	
			0°C	-5°C
520 {53}	580 {59}	28	55 {5.5}	35 {3.6}

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Cr	Ni	Cu
0.04	1.85	0.45	0.017	0.011	0.50	0.35	0.40