

Dual Shield 7100

AWS A5.20 E71T-1C / JIS Z3313 T49J0T1-1CA-U

Flux
CORED
WIRES

Description

- Dual Shield 7100 is an all position flux-cored electrode designed for optimum performance when using 100% CO₂ shielding. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. Fillet contour is flat to slightly convex with equal leg lengths and uniform sidewall wetting. 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%CO₂

Application

- The Dual Shield 7100 electrode is designed for all position single and multipass welding of low and medium carbon steels.
Performs well over normal rust and mill scale.

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	-20 °C
520 {53}	580 {59}	29	100 {10.2}	64 {6.5}

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S
0.04	1.27	0.57	0.015	0.005

Approvals

ABS, LR, DNV, BV, GL, RINA, NK, KR, JIS