

# Dual Shield 7100S

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

Flux  
CORED  
WIRES

## Description

- Dual Shield 7100S is an all-position wire with a bright surface finish that is uniquely designed to provide high deposition rates, high efficiency, and lower fume emission rates than other flux cored wires. It is optimized for use with 100% CO<sub>2</sub> shielding.
- Among the outstanding features of Dual Shield 7100S are a very wide operating window, excellent feedability and arc starting characteristics, attractive weld appearance, a thin easily removed slag, and welds that are virtually spatter free.

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

## Application

- Dual Shield 7100S 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)	
			0 °C	-20 °C
500 {51}	570 {58}	30	118 {12.0}	72 {7.3}

## Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S
0.04	1.41	0.58	0.011	0.009

## Approvals

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