

Dual Shield 7100SR

AWS A5.20 E71T-1C/9C-J/12C-J / JIS Z3313 T492T1-1CAP-U

Description

- Dual Shield 7100SR is an all-position wire with a uniquely balanced formulation to provide greater deposition and improved welding productivity. The low spatter levels and easy slag removal minimizes post weld cleanup.

Flux
CORED
WIRES

Shielding Gas : 100%CO₂

Application

- Welding for Nuclear Power Plant(CLP), off-shore and shipbuilding because of Dual Shield 7100SR is good impact value after PWHT at low temperature down to -20°F (-29°C)

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)			PWHT
			-30°C	-40°C	-46°C	
476 {49}	559 {60}	30	120 {12.3}	105 {10.7}	85 {8.7}	As-Welded
458 {48}	530 {56}	31	118 {12.0}	103 {10.5}	79 {8.0}	620°C x8hr

Typical Undiluted Weld Metal Analysis %

C	Mn	Si	P	S	Ni
0.047	1.40	0.55	0.012	0.008	0.44

Approvals

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