



CEWELD OA S-71-TGS

TYPE Self-shielded flux-cored wire for C. and C-Mn steels.

APPLICATIONS Welding outside in case high speed welding is required and protective gas is not easy to apply or possible.

PROPERTIES Very good welding characteristics and not sensitive for old and rusty base-materials, good mechanical properties and stable arc for welding in all positions. To be used on direct current electrode negative (DC-).

CLASSIFICATION

| | |
|--------|---------------------------|
| AWS | A 5.20: E71T-GS |
| EN ISO | 17632-A: T 42 Z W N 1 H15 |
| F-nr | 6 |
| FM | 1 |

SUITABLE FOR

| | |
|-----------------------|--|
| ASTM | EN |
| A 131 Gr A, B, D | 10025 S185, S235, S275, S355 |
| A 131 Gr AH32 to DH36 | 10028-2 P235 G H, P265 G H, P295 G H, P355 G H |
| API 5LX | 10113-2 S275, S355 |
| - | 10113-3 S275, S355 |

APPROVALS CE

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C | Si | Mn | Al | P | S |
|------|-----|-----|-----|-------|-------|
| 0.15 | 0.4 | 0.9 | 1.4 | 0.015 | 0.015 |

MECHANICAL PROPERTIES

| Heat Treatment | R _{p0,2} (MPa) | R _m (MPa) | A ₅ (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded | 450 | 540 | 22 | HRc |

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175



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OA S-71-TGS 0,9MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| D-100 | 0,9 | 8720663406071 |
| D-200 | 4,5 | 8720663406088 |
| D-300 | 15 | 8720663406095 |

OA S-71-TGS 1,2MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| D-200 | 4,5 | 8720663406118 |
| D-300 | 15 | 8720663406101 |

OA S-71-TGS 1,6MM

| Packaging | KG/unit | EanCode |
|-----------|---------|---------------|
| D-300 | 15 | 8720663406125 |