

# OA S-71-TGS

CATEGORY	FCAW Flux-Cored
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.

CLASSIFICATION	AWS 5.20: E 71 TGS
	EN ISO 17632-A: T 42 Z WN 1 H15

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

APPROVALS	CE approved
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## WELDING POSITIONS:



## WELD METAL ANALYSIS %

C	Mn	Si	Al
0.15	0.90	0.38	1.40

## MECHANICAL PROPERTIES

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HB
				-20°C	-40°C	-60°C	
AW	430	520	22				

AW: as welded

## WELDING PARAMETERS / PACKING

Welding Parameters			Packing	
D (mm)	Voltage (V)	Current (A) (DC-)	spool types	kg / spool
0.9			D-200 / S-300	5 / 15
1.2			D-200 / S-300	5 / 15
1.6			D-200 / S-300	5 / 15
2.4			S-300	15

REDRYING TEMPERATURE	150°C / 24hr
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