

AWS A5.20 / ASME SFA5.20 E71T-1C JIS Z3313 T49J 0 T1-1 C A-U H10 EN ISO 17632-A-T 42 0 P C 1

Applications





All position welding of building, shipbuilding, bridges, machinery and vehicles.

Characteristics on Usage

STELIO-71 is a titania type flux cored wire for all position welding with CO₂. Compared with solid wire, spatter loss is low, bead appearance is beautiful and arc is soft with good stability. Slag covering is uniform with good removal.

Notes on Usage

- ① Proper preheating(50~150° C)(122~302° F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
- ③ Use 100% CO₂ gas

Welding Position				Current	Shielding Gas
				DC +	CO ₂
1G (PA)	2F (PB)	3G (PF.PG)	4G (PE)		

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.04	0.49	1.29	0.010	0.009

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
548 (79,600)	582 (84,500)	28	0 (32)	86 (64)

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	120~300	200~350	200~400
V-up, OH	120~260	180~280	180~280
V-down	200~300	220~320	250~300