

PRODUCT DATA SHEET

Afrox Coremax 71



Coremax 71 is a rutile type CO₂ shielded flux cored wire for the welding of carbon manganese steels. It is recommended for the all-positional welding of mild and low alloy steels with a tensile strength of up to 620 MPa for general-purpose fabrication. Coremax 71 also provides increased toughness at sub-zero temperatures.

Classifications

| | | |
|-----|-------|--------|
| AWS | A5.20 | E71T-1 |
|-----|-------|--------|

Approvals

Det Norske Veritas

Bureau Veritas

Typical Chemical Analysis (All weld metal)

| | | | |
|-------------|------|---------------|------|
| % Carbon | 0,04 | % Sulphur | 0,01 |
| % Manganese | 1,32 | % Phosphorous | 0,02 |
| % Silicon | 0,42 | | |

Typical Mechanical Properties (All weld metal using CO₂ gas)

| | |
|-------------------------|---------|
| Yield Strength | 540 MPa |
| Tensile Strength | 580 MPa |
| % Elongation on 5d | 28 |
| Charpy V-Notch at -18°C | 65 J |

Welding Data (DC+) Shielding Gas: CO₂

| Diameter (mm) | Position | Current | | Deposition Rates (kg/h) | Electrode Stick Out (mm) |
|---------------|----------------------|-----------|-----------|-------------------------|--------------------------|
| | | Amps (A) | Volts (V) | | |
| 1,2 | Flat/horizontal | 260 | 27 | 4,1 | 12,0 |
| 1,2 | Vertical-up/overhead | 170 - 220 | 23 - 25 | 2,0 - 3,4 | 12,0 |
| 1,6 | Flat | 360 | 29 | 5,5 | 25,0 |
| 1,6 | Horizontal | 280 | 26 | 3,6 | 25,0 |
| 1,6 | Vertical-up/overhead | 215 - 245 | 24 - 25 | 2,6 - 3,0 | 25,0 |

Typical Values

Packing Data

| Diameter (mm) | Spool Mass (kg) | Item Number |
|---------------|-----------------|-------------|
| 1,2 | 15,0 | W081130 |
| 1,6 | 15,0 | W081131 |

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