BOHLER Q 71 RC-HP (C1)

Flux Cored Wire for High Impact strength

Classification

AWS A5.20	EN ISO 17632 – A / EN ISO 17632 – B
E71T-1C/ E71T-9C J	T 46 4 P C1 1 H5 / T 49 4 T1-1C1 A-NI-H5

Characteristics and field of use

BOHLER Q 71 RC-HP (C1) is Rutile flux cored wire specially designed for positional welding and to achieve good impact down -40 °C. Weldability characterized by fast freezing slag, less spatter, fine droplet transfer at low & high welding parameters enables easy slag removal; very less post weld cleaning operation produces X-Ray quality weld deposit.

It gives excellent mechanical properties and is suitable for welding of hulls, storage tanks, bridges, water wall panels, structures, ship building and constructional steel.

Base Materials

SA 516-Gr.60, Gr. 65, IS 2062, Gr. A, Gr. B, A 36, SA 106 Gr. B, S 235 JR, S275JR, S355 JR (st33, st37-2, st44-2, st52-3), P235 HG, API 5L X42-60, AH32, EH-36, A40 –F40 etc.

Typical Composition of all weld metal (wt. - %)

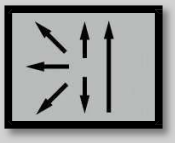
C	Si	Mn	S & P	Ni
0.04	0.40	1.35	0.015	0.5

Typical Mechanical Properties of all weld metal

Condition	Yield strength R_e N/mm²	Tensile strength R_m N/mm²	Elongation (L_0=5d_0)	Impact Test Values (J)
	MPa	MPa	%	-40 °C
As welded	510	590	26	90

Operating data

Position



Polarity

+ / DCEP

Re-drying/baking conditions: NA

Shielding Gas : 100% CO_2

Ø(mm)	Amps
1.20	120 - 280

Size & Packaging (Vacuum Packed)

Size(mm)	Kg/Spool
1.20	15.0

Approvals

CE, DNV, ABS, IBR

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.