

ROYAL PRIME-71

AN ALL POSITION RUTILE TYPE FLUX CORED WIRE
FOR MAG/MIG WELDING

BASIC ALLOY: FE, MN, SI
AWS/SFA-5.20: E71T-1C/1M
EN ISO 17632 B T492 T1-
1C/MA-H5

KEY FEATURES:

Titania type Flux-cored welding wire suitable for all welding position of mild steel and structure steel, suitable for high tensile steel up to 510 N/mm². The slag full coverage on weld bead and easy to remove. The smooth and stable arc and wire surface special coating provided for very long shelf life and smooth wire feeding. Weld metal is gives radio graphically sound

APPLICATIONS

- for chemical machinery equipment
- shipbuilding
- Automobile industry
- bridges, towers, rolling stocks etc

SHEILDING GAS

- Welding with CO₂ gas and Ar+ CO₂ gas mixture.

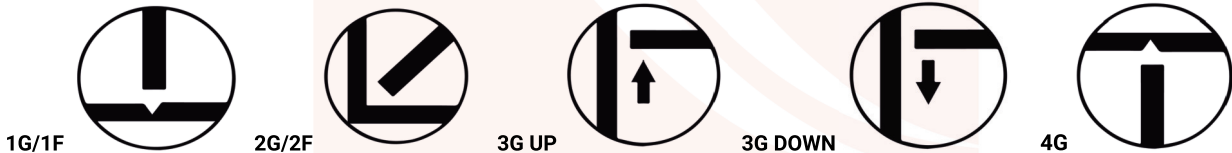
CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.055	1.42	0.58	0.030 Max	0.030 Max

MECHANICAL PROPERTIES

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
460-550	550-640	22-32	0C : 80-100 J Minus 20C : 50-80

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg.	Spool packing 15kg	Drum packing 100/200kg
1.20	3/ 64"	120-300	24-34	15-25	✓	✓	✓
1.40	1/ 18"	160-340	26-34	15-25	✓	✓	✓
1.60	1/ 16"	180-360	28-36	15-30	✓	✓	✓