

Classifications

AWS A5.36

AWS A5.36M

E71T8-A4-K6

E491T8-A4-K6

Characteristics and typical fields of application

Böhler Pipeshield 71 T8-FD is a self-shielded flux cored wire especially developed for vertical down welding of filler and cap layers in pipeline applications. It is also suitable for welding of low alloyed steel constructions. The wire offers excellent welding characteristics with high productivity. It has a fast freezing, easily removable slag system.

The weld metal shows excellent mechanical properties and superior impact toughness at low temperatures.

Due to the fluoride-basic filling, the recommended interpass temperature is 80 – 200°C.

Base materials

Acc. to API 5L:

A, B, X42, X46, X52, X56, X60, (X65, X70)

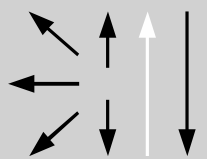
Typical analysis of all-weld metal (wt.-%)

	C	Si	Mn	Al	Ni
wt.-%	0.045	0.14	1.1	0.8	0.7

Mechanical properties of all-weld metal

Condition	Yield strength R _{eH}	Tensile strength R _m	Elongation A (L ₀ =5d ₀)	Impact work ISO-V KV J		
	MPa	MPa	%	+20 °C	-30 °C	-40 °C
	435 (≥ 400)	535 (490 – 660)	28 (≥ 22)	200	150	100 (≥ 27)

Operating data

	Polarity: DC (-)	ø (mm) 2.0
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Recommended stick out: 10 – 25 mm

Packaging and available sizes

6 kg coils: 1 unit contains 5 packed coils à 6 kg
Hermetically sealed metal can

Approvals

NAKS, GAZPROM