

## Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.29 / SFA-5.29
T38 3 Z1Ni Y NO 1 H10	T49 3 T8-1 NO A-GNi1-U H10	E71T8-K6

## Characteristics and typical fields of application

Böhler Pipeshield 71 T8-FD self-shielded flux-cored wire, especially developed and recommended for pipe welding in vertical down (5G) position. It is also suitable for welding of unalloyed steel constructions. This wire offers a fast freezing, easy removable slag, excellent welding characteristics, is easy to operate for the welders and this product provides high productivity.

Böhler Pipeshield 71 T8-FD is designed to provide good mechanical properties as well as high impact toughness at low temperatures. Basically outstanding benefits and advantages in vertical down position for (hot pass), fill and cap layers. Due to the fluoride-basic filling the interpass temperature can be arranged similar to that of basic electrodes, we recommend 80 – 200°C.

Böhler self-shielded flux-cored wire provide an easy handling for the welder due to a very tolerant stick out length and loss tendency to porosity also when welding with a longer arc length as a result of higher voltage.

## Base materials

Acc. to API 5L:

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

## Typical analysis

	C	Si	Mn	Ni	Al
wt.-%	0.045	0.20	1.3	0.8	0.8

## Mechanical properties of all-weld metal - typical values (min. values)

Condition	Yield strength $R_e$	Tensile strength $R_m$	Elongation A ( $L_0=5d_0$ )	Impact energy ISO-V KV J		
	MPa	MPa	%	+20°C	-30°C	-40°C
u	420 (≥ 400)	535 (490 – 660)	28 (≥ 20)	200	150 (≥ 47)	140

u untreated, as welded - without shielding gas

## Operating data

	<b>Polarity</b>	DC-	<b>Dimension mm</b>
	<b>Shielding gas (EN ISO 14175)</b>	NO GAS	2.0

Recommended stick out: 10 – 25 mm

## Approvals

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