



DUAL SHIELD 7100 LH

All position rutile, low-hydrogen flux cored wire for mild and medium tensile steels

Classification AWS A5.20: E71T-1C/E71T-1M

DESCRIPTION

DUAL SHIELD 7100 LH is a multi-purpose all positional rutile, low hydrogen cored wire for use with CO₂ or Ar/CO₂ shielding gas. The wire is suitable for all mild and medium tensile steels. The running characteristics are exceptional with a stable arc, low spatter and flat welds.

APPROVALS: ABS, BV, DNV, IRS & LRS

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO₂ or 80%Ar/20%CO₂

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.06	YS (N/mm ²)	480
Si	0.50	UTS (N/mm ²)	610
Mn	1.25	Elongation (%)	24
		Impact (CVN) @ -20°C (Joules)	60

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.2	150-350	23-35
1.6	150-450	22-36

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg.

DUAL SHIELD 7100

FCAW wire for mild steel and 490N/mm² class high tensile strength steel

Classification AWS A5.20: E71T-1C

DESCRIPTION

DUAL SHIELD 7100 is a multi purpose all position flux cored wire for use with CO₂ gas. The smooth metal transfer facilitates easy deposition in vertical-up welding. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity.

APPROVALS: ABS, BV, CCS, DNV, KR, LR & NK

WELDING CURRENT: DC+

SHIELDING GAS: 100%CO₂

TYPICAL PROPERTIES

Weld Metal Composition (Wt.%)		All Weld Mechanical Properties	
C	0.04	YS (N/mm ²)	490
Si	0.55	UTS (N/mm ²)	560
Mn	1.25	Elongation (%)	30
		Impact (CVN) @ 0°C (Joules)	90
		@ -20°C (Joules)	50

CURRENT RANGE

Size (mm)	Current (Amp)	Voltage (V)
1.2	140-330	22-34
1.4	150-390	22-35
1.6	160-460	23-36

PACKING: The wire can be supplied in plastic spool packed in a cardboard box weighing 12.5/15.0 kg or select sizes in Marathon Pac weighing 100/200/300 kg.