

Supershield 71GS

TYPE : Self-Shielded

AWS A5.20 /ASME SFA 5.20 E71T-GS
JIS Z3313 T49 T14-1 N S
EN ISO 17632-A-T 42 Z Z V N 1

Applications

Supershield 71GS is used where light structurals, short assembly welds, other general fabrications and galvanized steel fixtures, gate etc.

Characteristics on Usage

Supershield 71GS is an all position self-shielded flux cored wire designed for single-pass welding of thin mild and medium tensile steels not exceeding 510MPa.

Notes on Usage

① Do not use shielding gas.

Welding Position



1G 2F 3G 4G
(PA) (PB) (PF) (PE)

Current

DC -

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Al
0.26	0.50	0.91	0.016	0.014	2.05

Typical Mechanical Properties of All-Weld Metal

As Welded	
Transverse Tensile Strength, MPa(ksi) (Specimen broken in the base metal)	586 (85,000)
Longitudinal Guided Bend Test	Satisfactory

Approval

I Packing

-	Dia. (mm)	1.0	1.2	1.4	1.6	Spool(kg)	15	20
	(in)	.039	.045	.052	1/16	(lbs)	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.0 (.039)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F	80~200	160 ~ 220	170 ~ 250	180 ~ 280
V-up, OH	55~120	120 ~ 180	140 ~ 200	160 ~ 220