

LINCOLN® 71C

TYPICAL APPLICATIONS

LINCOLN® 71C is a gas shielded, general purpose, flux-cored welding wire designed for all position welding of mild steel applications requiring moderate levels of strength and very good notch toughness. LINCOLN® 71C should be used with CO₂.

ADVANTAGE LINCOLN

- Excellent mechanical properties
- Slag system provides for puddle support, good wetting, and bead shape in all positions
- Arc action and metal transfer are smooth
- Slag removal is easily achieved with hand tools
- Applications include those in general fabrication, ship or barge construction, building or bridge erection, and off-shore industries

CONFORMANCE

- AWS A5.20/ASME SFA-5.20:E71T-1C

WELDING POSITIONS



SHIELDING GAS

- 100% CO₂ shielding gas

APPROVALS

- ABS, TUV-CE, DNV-GL, LR, RINA

PACKAGING TYPE

- All spools of wire are level layer wound on plastic spools.
- The spools are then vacuum-packed in moisture proof, poly foil bags.
- The spools of wire are boxed and securely stacked on wooden pallets with plastic shrink-wrap.

DIAMETERS / PACKAGING

Diameter(mm)	Spool/Drum Weight(kg)	Pallet Weight(kg)	Product No.
1.2	5	1,000	COLC71CE23
1.2	15	1,080	COLC71CE21
1.6	15	1,080	COLC71CE61

WELD DEPOSITE CHEMICAL COMPOSITIONS (Wt-%) -- TYPICAL

	C%	Mn%	Si%	P%	S%
AWS Requirements E71T-1C Max	0.12	1.75	0.90	0.030	0.030
Test Results (with 100%CO ₂)	0.06	1.21	0.36	0.019	0.010

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ALL WELD METAL MECHANICAL PROPERTIES -- TYPICAL

	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Impact (J) @-20°C
Requirements AWS E71T-1C	400 min	490-670	22 min	27 min
Test Results With 100%CO ₂	475	560	30.5	156

TYPICAL OPERATING PROCEDURES

Diameter Polarity CTWD mm(inches)	Wire Feed Speed in/min (cm/min)	Voltage (V)	Approx.Current (A)	Melt-Off Rate Kg/hr (lb/hr)	Deposition Rate Kg/hr (lb/hr)
1.2mm DC+ 20[3/4"]	175 [445]	21-24	130	1.8	1.5
	225 [572]	23-25	165	2.4	1.9
	275 [699]	25-27	185	2.9	2.4
	325 [826]	26-29	200	3.4	2.9
	375 [953]	27-29	230	4.0	3.3
	425 [1,080]	28-30	250	4.5	3.7
	475 [1,207]	29-31	270	5.0	4.2
	600 [1,524]	31-33	310	6.2	5.3
1.6mm DC+ 25[63/64"]	130 [330]	22-25	180	2.6	2.2
	150 [381]	23-26	210	3.0	2.5
	200 [508]	24-27	265	3.9	3.2
	250 [635]	26-29	305	4.9	4.1
	300 [762]	28-31	345	5.8	4.9

Customer Assistance Policy

The business of The Lincoln Electric Company is manufacturing and selling high quality welding equipment, consumables, and cutting equipment. Our challenge is to meet the needs of our customers and to exceed their expectations. On occasion, purchasers may ask Lincoln Electric for advice or information about their use of our products. We respond to our customers based on the best information in our possession at that time. Lincoln Electric is not in a position to warrant or guarantee such advice, and assumes no liability, with respect to such information or advice. We expressly disclaim any warranty of any kind, including any warranty of fitness for any customers particular purpose, with respect to such information or advice. As a matter of practical consideration, we also cannot assume any responsibility for updating or correcting any such information or advice once it has not been given, nor does the provision of information or advice create, expand or alter any warranty with respect to the sale of our products.

Lincoln Electric is a responsive manufacturer, but the selection and use of specific products sold by Lincoln Electric is solely within the control of, and remains the sole responsibility of the customer. Many variables beyond the control of Lincoln Electric affect the results obtained in applying these types of fabrication methods and service requirements.

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The product performance data of this brochure and related attachments are from LINCOLN ELECTRIC application engineering laboratory.

Except for special instructions, experiments on welding machines are conducted in accordance with the general standard of IEC60974-1; experiments on welding consumables are conducted in accordance with the general standard of AWS; for specific applicable standards on welding consumables please refer to the product page.

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THE SHANGHAI LINCOLN ELECTRIC CO., LTD.

No.195, Lane 5008, Hu Tai Road, Shanghai China 201907

TEL:86-21-6673 4530

FAX:86-21-6602 6621

www.lincolnelectric.com.cn