

FabStar 71

AWS A5.20 E71T-1C
EN ISO 17632-A-T 46 2 P C1 1 H10
JIS Z 3313 T49J 0 T1-1 C A-U

Characteristics and Applications:

FabStar 71 is designed for the mild steel and 490N / mm² high-tension steel with the gas shield coating line. Welding operation is good, less dust, arc soft and stable. Especially in the horizontal fillet welding and docking position, the weld bead is formation, welding slag are thin and easy to remove with melt filling high efficiency, and anti-cracking and X-ray detection performance is excellent, which particularly suitable for steel and lifting industry welding.

Notes on Usage:

1. With DC positive electrode DC + (wire bonding) welding.
2. Use CO₂ or 75%Ar+25% CO₂ as protective gas.
3. Transport and storage should pay attention to moisture.

Typical chemical composition of weld metal (wt%)

	C	Mn	Si	P	S
AWS	≤0.12	≤1.75	≤0.90	≤0.03	≤0.03
EN ISO	-	≤2.0	-	-	-
CO ₂	0.05	1.34	0.45	0.017	0.005
75%Ar+25% CO ₂	0.06	1.52	0.65	0.017	0.006

Typical mechanical properties of weld metal :

	Yield strength MPa(ksi)	Tensile strength MPa(ksi)	Elongation %	Charpy V-Notch J (ft-1bf)	
				-20°C(0°F)	-30°C(-20°F)
AWS	≥390(58)	490-670(70-95)	≥22	≥27(20)	≥27(20)
EN ISO	≥460(67)	530-680(77-99)	≥20	≥47(35)	-
CO ₂	530(77)	585(85)	28	70(52)	45(33)
75%Ar+25% CO ₂	555(81)	630(91)	27	90(66)	85(63)

Welding position



Sizes and recommended parameter range (DC < + >):

Stick out : 15-25 (mm), gas flow rate : 20-25 (l/min)

Position	Diameter (mm)	1.2	1.6
	F, HF		160A~300A / 22V~34V
H		200A~260A / 23V~28V	200A~400A / 28V~42V
VU, OH		140A~220A / 22V~28V	160A~280A / 22V~28V

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