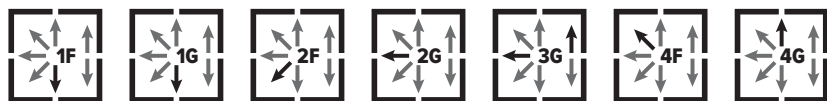


HYPER[⚡]SHIELD 71T+

FLUX-CORED GAS-SHIELDED



Summary

HYPERSHIELD 71T+ is a titania-type flux-cored wire designed for all-position welding. It boasts excellent mechanical properties, offering easy slag removal alongside reduced spatter. The result is a smooth bead surface that provides the utmost confidence during X-ray inspections, ensuring weld integrity. This wire also stands out for its exceptional impact resistance, even at temperatures as low as -40°C.

Typical Applications

- Structural steelwork
- Earth-moving equipment fabrication
- Shipbuilding and repair
- Storage tank construction
- Bridge construction and maintenance
- Heavy machinery assembly
- Industrial equipment manufacturing
- General fabrication involving medium to high-strength steel

Classification

- AS/NZS ISO 17632-B: T49 4 T12-1 M A U H5

Standards

- AWS A5.20 E71T-12M J H4

Recommended Gas

- 100% CO₂
- Ar+20-25% CO₂

Packaging Info

SKU	Wire Size	Weight	Description
U61008	1.2mm	15kg	HYPERSHIELD 71T+ FLUX-CORED GAS-SHIELDED WIRE 1.2MM 15KG
U61009	1.6mm	15kg	HYPERSHIELD 71T+ FLUX-CORED GAS-SHIELDED WIRE 1.6MM 15KG

Operating Polarity

- DCEP

Typical Chemical Composition (%)

C	Mn	Si	P	S	Ni
0.030	1.100	0.480	0.010	0.010	0.330
Cr	Mo	V	Cu		
0.020	0.010	0.010	0.010		

Typical Mechanical Analysis

Yield Strength	559
Tensile Strength	578
Elongation	29
Test Temp. (°C)	-40
Absorbed Energy (J)	78

Recommended Welding Parameters (DCEP)

Position/diameter (mm)		1.2	1.6
Flat	Current (A) Voltage (V)	180–340 A 24–36 V	200–420 A 26–42 V
Horizontal Fillet		180–340 A 24–36 V	200–420 A 26–42 V
Vertical Up		140–260 A 24–30 V	200–300 A 26–32 V

Shielding gas: Ar + 20–25% CO₂

Gas flow 20–25 L/min; contact-tip-to-work distance 15–25 mm; for multi-pass welds with multiple layers, keep preheat and interpass below 150°C; use a wind screen at ≥7.2 km/h.

Country of Origin

- Made in South Korea 