

#### DESCRIPTION

Executive 71CM is a high quality, general purpose flux cored wire intended for single and multi-pass applications in both flat and out of position welding.

Executive 71CM is an easy to use wire that offers low fume generation, minimal spatter levels, and an easy to remove slag.

Certified test reports that include certification to AWS D1.8 for critical seismic applications with actual chemistry and mechanicals for both 100% CO<sub>2</sub> and 75% Ar / 25% CO<sub>2</sub> shielding gases are provided with each lot.

#### APPLICATIONS & FEATURES

Executive 71CM wire is easy to use with very smooth arc characteristics allowing for great operator appeal. Executive 71CM is a very consistent wire that produces an excellent bead profile and good mechanical properties.

Typical applications include structural steel welding, pressure vessels, bridges, transportation equipment, as well as all general fabrication where high productivity and good mechanical properties are required.

#### TYPICAL WIRE CHEMISTRY & MECHANICAL PROPERTIES

C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V
0.05	0.57	1.44	0.014	0.007	0.01	0.01	0.02	0.001	0.02
<b>Tensile Strength:</b>	83,500 PSI min		<b>Diffusible Hydrogen:</b> 3.86 ml/100g			<b>Charpy Impact:</b> 76 ft-lb (103 J) at -4°F (-20°C)			
<b>Yield Strength:</b>	72,600 PSI min		<b>Elongation:</b> 31%			<b>Radiographic Test:</b> Acceptable			

#### TYPICAL WELDING PARAMETERS

Diameter	Voltage	Amperage	Wire Feed Speed (in./min)	Stick-Out	Flow Rate (SCFH)	Shielding Gas*
.035"	21-23	115	275	5/8 - 3/4"	35	75% Ar / 25% CO <sub>2</sub>
	23-26	155	400			
	25-27	200	550			
	27-29	240	650			
.045"	21-24	140	205	3/4"	40-50	75% Ar / 25% CO <sub>2</sub>
	23-26	200	340			
	26-29	240	430			
.052"	22-25	160	145	3/4" - 1"	40-50	75% Ar / 25% CO <sub>2</sub>
	24-27	220	235			
.062"	27-30	280	345	3/4" - 1"	40-50	75% Ar / 25% CO <sub>2</sub>
	23-26	200	120			
	27-30	320	270			

\*If using 100% CO<sub>2</sub>, increase by 2 volts.

#### STANDARD PACKAGING

<b>Spools</b>	33-lb & 44-lb plastic spools	1,980-lb & 2,640-lb pallet
<b>Drums</b>	.045" 440-lb ea	880-lb pallet 20" diameter
	.052"/.062" 660-lb ea	1,320-lb pallet 26" diameter

#### CLASSIFICATION

AWS A5.20/ASME SFA A5.20 Class E71T-9C/9M H8  
 AWS A5.36(M)/ASME SFA A5.36(M) Class E71T1-C1A2(A3)/M21A2(A3)-CS1-H8  
 CWB to CSA W48 Class E491T1-C1A3/M21A3-CS1-H8 (E491T-9-H8 & E491T-9M-H8)  
 Meets AWS D1.8 for Seismic Applications. ABS 3YSA H10

