

**Technical
data sheet**

201114

Cored welding wire
ROBOFIL M 71 Zn**CLASSIFICATION**

ASME IIC SFA-5.18 / AWS A 5.18

E70C-GS

EN ISO 17632-A

T 46 Z Z M M 1 H5

EN ISO 17632-B

T55ZT15-1MA-G-UH5

ASME IX Qualification

QW-432 F-No 6 QW-442 A-No 1

DESCRIPTION

- Seamless copper coated metal cored tubular wire for semi-automatic gas shielded arc welding
- Designed for single and multipass welding of galvanised steels
- Contains purifying and deoxidising additions to counteract the effect of zinc uptake on the weld metal
- H_{DM} guaranteed < 4 ml/ 100g deposited metal
- No moisture pick up, excellent wire feeding properties, good weldability and low spatter

APPLICATIONS

Galvanised non-alloyed constructional steel, boiler plate, pipe steels, fine-grained steels, shipbuilding steels

Examples

St12, St13, St14

ZStE 260 to ZStE 420

StE 250-2Z to StE 305-3Z

TYPICAL ALL WELD METAL ANALYSIS

C	Mn	Si	Fe
0.1	1.6	0.6	Balance

MINIMUM ALL WELD METAL MECHANICAL PROPERTIES

Rm [MPa]	Rp 0.2% [MPa]	A ₅ [%]
550	470	20

SHIELDING GASM21 (Ar + 15 - 25% CO₂) gas mixtures according to EN ISO 14175**OPERATING CONDITIONS**

Diameter [mm]	Current type	Current I [A]	Voltage [V]	Stick out [mm]
1.0	DC(+) or pulsed	70 - 250	15 - 30	12 - 20
1.2	DC(+) or pulsed	100 - 350	15 - 30	12 - 25

Robofil M 71Zn can be welded as well backhand (trailing) as forehand (pushing)

WELDING POSITIONS

Robofil M 71Zn is primarily used in the flat and horizontal-vertical positions. However, welds in other positions are also possible using the short-circuiting or pulsed arc modes of transfer.

PACKAGING

Diameter	1.0 mm	1.2 mm
	EN ISO 544 – ASME II C SFA-5.2 M	
Spool type	BS300 basket spool	
Weight	15 kg	

Other packaging: please consult us