

Union RV 71

Flux cored wire, low-alloyed, rutile

Classifications

EN ISO 17632-A	EN ISO 17632-B	AWS A5.20
T 46 4 P M 1 H5	T555T1-1MA-H5	E71T-1MJH4
T 46 2 P C 1 H5	T553T1-1CA-H5	E71T-1CH4

Characteristics and typical fields of application

Union RV 71 is a seamless copper coated rutile flux cored wire with fast freezing slag for allposition welding, according to EN ISO 14175, when using mixed gas M21, M31 and C1. It shows good mechanical-technological properties. The outstanding welding properties are the stable arc, the good modelling characteristic, the very low spatter proportion, finely rippled and notch free weld interface, and good slag detachability.

Due to the fast freezing slag out-of-position welding with increased current is possible for manual as well as for mechanized welding.

Grundwerkstoffe

S185, S235JR, S275JR, S355JR, P235GH, P265GH, P295GH, P355GH (HI, HII, 17 Mn 4, 19 Mn 6), P275N – P355NH, S275N – S420NL, L210 – L415NB, X 42 – X 60 (API-5LX),

GS-38 – GS-52, Shipbuilding steels Grade A – E, AH 32 – EH 36, A40 – F40

Typical ana	Typical analysis of all-weld metal (wt%)												
	С	Si			Mn	<i>l</i> In		Р		S		Gas	
wt-%	0.06	0.4		0.45		1.35		≤ 0.020		≤ 0.020		M21	
Mechanical properties of all-weld metal													
Heat- treatment	Shielding gas	Yiel stre R _{p0.}	eld Tens ength strer _{0.2} R _m		sile ngth	Elongation A ($L_0=5d_0$)		Impact work ISO-V KV J					
		MPa	a	MPa	a	%	+20 °C		;	±0 °C	–20 °C		–40 °C
aw	M21	460	1	530		22	120			90 70			47
Operating data													
Polarity: Shiel DC (+) (EN I M21		Shieldin (EN ISO M21, M3 Consum 15 – 18	ing gas: O 14175) v/31, C1 umption: 18 l/min		(mm) 1.0 1.2 1.4 1.6	Sp B3 B3 B3	ool 300 300 300	Amps A 130 – 270 160 – 300 180 – 350 200 – 375			Voltage V 21 – 30 22 – 32 23 – 32 24 – 33		
Approvals													
1.0 mm	D	DNV. LR											

- 1,0 mm 1,2 – 1,6 mm
- TÜV (11077), DB (42.132.32), ABS, DNV, GL, LR, CE