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 ISO 9001:2008 REGISTERED
 Certificate No.: 50040 & 50415

E71T-GS DATA SHEET

Pinnacle Alloys E71T-GS

AWS CLASS E71T-GS

CODE AND SPECIFICATION DATA:

AWS A5.20 ASME SFA 5.20

DESCRIPTION:

Pinnacle Alloys E71T-GS has many positive characteristics that make it the smart choice for the “hobbyist” welder, as it works very well on the popular small 110 volt power source/feeders. Pinnacle Alloys E71T-GS is designed for single pass welding of thin-gauge carbon steel, ranging from 3/16” to 22 gauge. This electrode is formulated to weld quite effectively over galvanized material and can be used on certain aluminized surfaces as well. Pinnacle Alloys E71T-GS requires no external gas-shielding and should be welded with DECN (straight polarity). Pinnacle Alloys E71T-GS is the natural choice for applications such as lap and butt welds on galvanized sheet metal, repair of automobile sheet metal, welding ductwork, and joining of galvanized roofing sheet metal.

DIAMETERS: .030”, .035”, .045”, .052”, 1/16”

WELDING POSITIONS: All positions



TYPICAL DEPOSIT COMPOSITION:

	AWS Spec	Weld Metal Analysis (%)
Aluminum (Al)	N.S.	1.30
Carbon (C)	N.S.	0.18
Manganese (Mn)	N.S.	0.65
Phosphorus (P)	N.S.	0.01
Silicon (Si)	N.S.	0.40
Sulfur (S)	N.S.	0.01

*N.S. means Not Specified.

NOTE: Single values are maximums.

SOWESCO, LLC

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TYPICAL MECHANICAL PROPERTIES:

	AWS Spec (min)	As Welded
Ultimate Tensile Strength	70,000 psi (490 MPa)	86,400 psi (595 MPa)

TYPICAL WELDING PARAMETERS:

Diameter	Position	Optimum			Amperage Range	Voltage Range
		Amperage	Voltage	WFS (ipm)		
.030"	Flat	125	15	215	115-135	14-16
	Overhead	100	15	170	90-110	14-16
	Vertical Up	100	15	170	90-110	14-16
.035"	Flat	170	16	225	160-180	15-17
	Overhead	125	17	160	115-135	16-18
	Vertical Up	125	17	160	115-135	16-18
.045"	Flat	200	17	190	190-210	16-18
	Overhead	170	17	155	160-180	16-18
	Vertical Up	170	17	155	160-180	16-18

NOTE: Parameters are with DCEN. Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of steel being welded.

NOTICE: The results reported are based upon testing of the product under controlled laboratory conditions in accordance with American Welding Society Standards. Actual use of the product may produce different results due to varying conditions. An example of such conditions would be electrode size, plate chemistry, environment, weldment design, fabrication methods, welding procedure and service requirements. Thus the results are not guarantees for the use in the field. The manufacturer disclaims any warranty of merchantability of fitness for any particular purpose with respect to its products.

CAUTION: Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.

Pinnacle Alloys SDS sheets may be obtained on the website below.