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E71T-GS DATA SHEET

Pinnacle Alloys E71T-GS

AWS CLASS E71T-GS, E71T-14

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.

CHARACTERISTICS:

- Performs well on galvanized material.
- Smooth and stable arc transfer with virtually no spatter emission.
- Soft arc transfer minimizes burn-through on thin gauge material.
- Good selection for use on popular 110 volt power sources.

SHIELDING GAS: Self-shielded

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

WELDING POSITIONS: All positions

TYPICAL DEPOSIT COMPOSITION:

Aluminum (Al)	1.30
Carbon (C)	0.18
Manganese (Mn)	0.65
Phosphorous (P)	0.01
Silicon (Si)	0.40
Sulfur (S)	0.01

TYPICAL MECHANICAL PROPERTIES:

Ultimate Tensile Strength (psi)	86,400 psi (base metal fracture)
Guided Bend Test	Meets AWS Requirements



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RECOMMENDED WELDING PARAMETERS (use DCEN):

Diameter	Welding Position	WFS (ipm)	Amperage	Volts	ESO (in.)
.030"	V-up, OH	170	100	15	3/8-1/2"
	Flat, Hor	215	125	15	
.035"	V-up, OH	160	125	17	3/8-1/2"
	Flat, Hor	225	170	16	
.045"	V-up, OH	155	170	17	3/8-1/2"
	Flat, Hor	190	200	17	
.052"	V-up, OH	100	170	17	1/2-3/4"
	Flat, Hor	115	230	17	
1/16"	V-up, OH	90	170	16	1/2-3/4"
	Flat, Hor	110	250	18	

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, 550 NW LeJune Road, 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 MSDS sheet may be obtained at www.pinnaclealloys.com.