



**WA. ALLOY CO.**

WASHINGTON ALLOY'S Quality Management System is certified to **ISO 9001:2008**  
Cert# 05-R0925

# E71T-GS SELF-SHIELDED WELDING WIRE

U.S. ALLOY CO.  
dba Washington Alloy  
7010-G Reames Rd.  
Charlotte, NC 28216  
[www.weldingwire.com](http://www.weldingwire.com)



**American Welding Society**  
Sustaining Company Member



## ALLOY DESCRIPTION AND APPLICATION:

USA E71T-GS is a flux cored, all-position, self shielded wire designed for welding applications where the use of an external shielding gas is not practical. USA E71T-GS is designed to weld a full strength bead in single pass applications, making it an ideal maintenance and repair rod for general field use, such as galvanized fence repair, farm equipment, tanks and non-structural frames. Usage should be limited to single pass welding. a second pass may be suitable in some applications, but multiple passes should be avoided. USA E71T-GS has a smooth stable arc, low spatter and easy slag removal. An excellent choice for lap and fillet welds on thin gauge material in all welding positions. Due to it's low penetration into the base material, this alloy is a great wire for on the spot repairs to hold broken parts together until they can be re-welded in a shop environment.

### TYPICAL WELDING PARAMETERS:

DC- Electrode Negative (Straight Polarity)

Amperage settings:

Dia.	Flat	Horizontal fillet	Vertical
.030	40-160	40-160	30-120
.035	60-180	60-180	50-140
.045	80-200	80-200	80-160
1/16	160-270	160-270	120-22

Electrical Stickout 3/8" up to 1" on heavier diameters.

### TYPICAL CHEMISTRY (%) & WELD METAL PROPERTIES

C	Mn	Si	Al	P	S
0.16	0.82	0.31	1.3	.014	.005

Transverse Tension Test - 75,000 psi

Longitudinal Guided Bend Test; Satisfactory

Elongation in 2" - 22%

### SPECIFICATIONS:

AWS A5.20, Class E71T-GS

EAST COAST  
7010-G Reames Rd  
Charlotte, NC 28216  
Tel (888) 522-8296  
Fax (704)598-6673

### AVAILABLE SIZES:

Dia. .030", .035", .045" & 1/16"

Spool size: 2 lb, 10 lb and 25 lb (1/16" not available on 2lb spools)

GULF COAST  
4855 Alpine Drive #190  
Stafford, TX 77477  
Tel (877) 711-9274  
Fax (281)313-6332

WEST COAST  
8535 Utica Ave  
Rancho Cucamonga, CA 91730  
Tel(800)830-9033  
Fax (909)291-4586

Warehouse Distribution Center – Dayton, Ohio

Head Office – Puyallup, Washington

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