

Coreshield 71T-8 OS

Coreshield 71T-8 OS is a self-shielded flux cored wire designed to weld critical structural applications such as TKY joints for offshore construction, pipe structures, bridges and storage tanks. It is designed to provide excellent low temperature impact toughness down to -40 degrees C. whilst maintaining great arc characteristics, high welder appeal and easy slag removal in all welding positions.

Classifications Weld Metal	SFA/AWS A5.29 : E71T8-Ni1 J H8 EN ISO 17632-A : T42 4 1Ni Y 1
Approvals	ABS E71T8-Ni1 J H8 CE EN 13479 CWB CSA W48-18 DNV IV Y40MS

Approvals are based on factory location. Please contact ESAB for more information.

Welding Current	DC-
Diffusible Hydrogen	<8
Alloy Type	C-Mn-Ni-Al

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
AWS			
As Welded	429 MPa (62 ksi)	521 MPa (76 ksi)	28 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
AWS		
As Welded	-40 °C (-40 °F)	172 J (127 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni	Al
0.06	1.05	0.15	0.003	0.006	0.93	0.92

Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate
2.0 mm (5/64 in.)	160-250 A	18-23 V	1.4-2.6 m/min (55-102 in./min)	1.1-2.3 kg/h (2.4-5.1 lb/h)