

# SL-71T

## Seamless FCAW Wire

For MIG/MAG Cored Wires C-Mn & low alloy steels

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**SL SERIES**  
SEAMLESS WELDING

Betaweld SL-71T is a seamless copper coated rutile flux cored wire for gas shielded metal arc welding of unalloyed steels for operating temperatures from -20°C up 450°C. The new formulation provides an extremely easily controlled weld pool and outstanding welding characteristics. Betaweld SL-71T is an ideal solution for positional welding of C-Mn steel for infrastructure, shipbuilding and general fabrications. It can be applied in all positions with only one parameter setting (24V/Wire feed @ 9.0m per min /1.2mm wire). Low spatter and easy slag removal, finely rippled and pore free welds are produced without undercut. Preferably use under mixed gas, the use of CO<sup>2</sup> is possible.



### Conformance

AS/NZS ISO	17632-B: T552T1-1CA-UH5
AS/NZS ISO	17632-B: T552T1-1MA-UH5
EN ISO	17632-B: T552T1-1CA-UH5
EN ISO	17632-B: T552T1-1MA-UH5
AWS	A5.20 E71T-1C-H4/1M-JH4
AWS	A5.36: E71T1-C1A0-CS1-H4
AWS	A5.36: E71T1-M21A0-CS1-H4

### Approvals

Approvals	Grade
ABS	3Y40SA H5
BV	SA3Y40M H5
DB	•
RINA	3Y40SA H5
TÜV	•



Manufactured in Europe

### Current condition and welding position

DC+

### Chemical analysis (Typical values in %)

C	Mn	Si	P	S
0.05	1.4	0.5	≤ 0.010	≤ 0.010

**Shielding Gas** - EN ISO 14175: CO<sub>2</sub>, M21

### Materials

S(P)235-S(P)460

Shipbuilding steels A,B,D,E,AH32 - EH36

X42 - X65

### Storage

Keep dry and avoid condensation

### All-weld metal Mechanical Properties

Heat Treatment	Yield Strength (Mpa)	Tensile Strength (Mpa)	Elongation A% (%)	Impact Energy ISO - V (J) -20° C
As Welded	≥ 460	550-650	≥ 24	≥ 80

Gas test: 82% Ar+18% CO<sub>2</sub>

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### SL-71T Operating Data

Wire Dia (mm)	Recommended Range	Recommended Range	Optimum Amperage	Optimum Voltage	Welding Positions
1.2mm	100-300A	22-32V	250A	28V	Flat
1.6mm	200-400A	22-32V	300A	30V	Flat
1.2mm	180-250A	23-28V	190A	24V	Vertical Up
1.6mm	200-260A	24-28V	210A	25V	Vertical Up

This operating data is given as a guide only. Actual settings will depend on the machine, material thickness, gas used and the operator techniques.

### SL-71T Packaging Data

Part No	Wire Diameter (mm)	Pack Description	Weight	Pallet	Size
2150	1.2mm	Spool/Carton	15kg	62 Spools	
2151	1.6mm	Spool/Carton	15kg	62 Spools	

