DevTek 71-12

All Position Flux Cored Wire

AWS A5.20 – E71T-12MJ, ASME SFA: A5.20 – E71T-12MJ,
AWS A5.20 – E71T-1M, ASME SFA: A5.20 – E71T-1M

Typical Applications:

- General Fabrication
- Bridge and Structural Steel Fabrication
- Casting Repair
- Shipbuilding
- Repair and Maintenance

Product Advantages:

- Flat, Horizontal, Vertical
- Smooth Arc with low spatter
- Flat bead with easy slag release
- Low moisture pick-up
- Excellent Toughness

Typical Mechanical Properties

	UTS (ksi)	Yield (ksi)	%El	CVN (ft/lbs)@-20F	CVN (ft/lbs)@-40F	CVN (ft/lbs)@-60F
AWS Spec. (min)	70-90	58	22	20	20	-
DevTek 71-12: As Welded	83	77	26	107	75	92
DevTek 71-12: SR 2hr @ 1175°F	84	71	29	96	42	38

Deposit Composition

	%C	%Mn	%Si	%Ni
AWS Spec.	0.12 max	1.60 max	0.90 max	0.50 max

Available Diameters: 0.045” (Additional sizes may be available upon request)

Typical Welding Parameters

Diameter	Amperage Range	Voltage	Current
0.045”	180-200	26	DCEP

Packaging: The product is packaged on 25 pr 50lb. spools with a vapor corrosion inhibitor strip, vacuum-packaged and placed in a specially designed carton for long term storage.

Moisture Control: Devasco electrodes are manufactured and packaged to resist moisture pick up. Electrodes should be stored in their original packaging in a clean, dry, environment with a temperature range of 40°F to 120°F with a maximum humidity of 80%. However, under exposure to the elements, the fluxing components may begin to absorb moisture. All exposed and unused electrodes may be baked at 300-325°F in a warming oven for a minimum of 2 hours prior to use.

NOTICE: Data provided is based on typical results. **Actual results are tested per customer spec**. Please contact customer service at 888-DEVASCO for modified chemistries, welding parameters, PWHT conditions, or Safety Data Sheets. Specification subject to change without notice. www.devasco.com for additional information.
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