

## OA S-71-T8

**CATEGORY** FCAW Flux-Cored

**TYPE** Open arc wire with high deposition rate and excelent all position properties at high currents..

**APPLICATIONS** Welding outdoors without sheltering with high deposition rates with a high basic slag. Suitable for C-Mn steels such as structural steel erection, bridge construction, fabrication of machinery, steel framed buildings and or heavy equipment repair.

**PROPERTIES** **OA S 71 T8** is able to Weld out of position at extreme currents and offers a Low hydrogen weld deposit. Excellent slag removal and protective gas is not required. High impact strength at low temperatures combined with excellent mechanical properties within a wide range of heat inputs.

- Usable under AWS D1.8 for use on Demand Critical welds.

**CLASSIFICATION** AWS A 5.20: E 71 T-8JD H8  
EN ISO 17632-A: T 42 2 Y N 2 H10

**SUITABLE FOR** Rebuilding and joining steel parts that requires good strenght and high productivity.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Al	S	P
0.19	0.55	0.20	0.6	0.006	0.009

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRC / HV
				-20°C	-40°C	-60°C	
AW	469	570	25	75			

AW: as welded

**WELDING PARAMETERS / PACKING**

Welding Parameters			Packing	
D (mm)	Voltage (V) (CV)	Current (A) (DC-)	spools type	kg / spools
1.6	18-24	170-280	D-200 / H-300	5.4 / 15
2.0	18-24	210-360	H-300	15

**REDRYING TEMPERATURE** not recomended

**HYDROGEN CONTENT** <6,7 ml/100gr