



DATA SHEET
DS 169
Rev. 04 dd 10/03/09
INETUB S71TGS

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CLASSIFICATION

APPROVALS

AWS SPECIFICATIONS	EN SPECIFICATIONS
AWS A 5.20: E71T-GS	EN ISO 17632-A: T 42 Z W N 1 H15

ALLOY TYPE

Self-shielded flux cored wire for welding carbon and carbon-manganese steels.

APPLICATIONS

Open-arc flux cored wire (self-shielded) designed for welding thin carbon and carbon-manganese steels in all positions. Easily removable slag, versatility and manuality; suitable for welding zinc-coated plates as well. Completely free of barium salts. Applications include tanks, boilers, steel structural works (large thickness), earthworks and construction works. To be used on DC- (DC operation, electrode negative polarity).

MATERIALS TO BE WELDED

ASTM		EN		Others
A 131 Gr A, B, D		10025 Gr S185	10028-2 P355 G H	
A 131 AH32 fino DH36		10025 Gr S235	10113-2 S275	
API 5LX		10025 Gr S275	10113-2 S355	
		10025 Gr S355	10113-3 S275	
		10028-2 P235 G H	10113-3 S355	
		10028-2 P265 G H		
		10028-2 P295 G H		

WELDING GUIDELINES

Preheat and PWHT are not required.

TECHNICAL INFORMATION

Gas: open-arc
 Welding positions: all positions



WELDING PARAMETERS

Current	DC - Straight polarity					
	Diameter (mm)	0.8	0.9	1.0		
Volts (V)	18 ÷ 21	19 ÷ 23	19 ÷ 24			
Intensity (A)	100 ÷ 130	110 ÷ 150	120 ÷ 170			



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TYPICAL CHEMICAL COMPOSITION OF WELD METAL

GAS	C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Al
open-arc	0.17	0.90	0.38	0.008	0.014	-	-	-	1.40

TYPICAL MECHANICAL PROPERTIES

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-30°C	-40°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
open-arc	as welded	450	560	23	-	-	-	-	-

PRODUCTS AVAILABLE

Process	Product	Classification AWS	Classification EN
MIG/MAG Solid wire			
TIG Rods			
SAW Submerged arc			
FCAW Cored wire	INETUB S71T11 INETUB BA71TGS INETUB BA71T11	AWS A 5.20: E71T-11 AWS A 5.20: E71T-GS AWS A 5.20: E71T-11	EN 17632-A: T 42 Z W N 1 H15 EN 17632-A: T 42 Z W N 1 H15 EN 17632-A: T 42 Z W N 1 H15
SMAW Electrodes			