

TOKO E71T-9CJ

TOKO®

Flux Cored Wire for High Strength Steel

TOKO AWS A5.20 E71T-9CJ is a cost-effective quality rutile flux cored wire designed for all-positions welding with 100% CO₂ shielding for excellent CVN impact performance at -40°C. This wire offers optimum welding performance under soft and stable arc with less fume and spattering. Produce smooth bright and flat weld bead with easy slag removal.

Classifications

AWS A5.20 E71T-9CJ
ISO 17632-A: T42 4 P C1 1

Typical all weld metal composition, wt. %

	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	≤0.12	≤1.75	≤0.90	≤0.20	≤0.50	≤0.30	≤0.03	≤0.03	≤0.08
Typical	0.055	1.18	0.33	0.024	0.332	0.004	0.010	0.003	0.018

Mechanical properties of all well metal

	Heat Treatment	Yield Strength (MPa)	Tensile Strength (MPa)	Elongation (%)	Charpy V (J/°C)
AWS	As welded	390	490-670	22	27J/-40°C
Typical	As welded	470	540	27	80J/-40°C

Operating Parameters

Polarity	Shielding	Current (A)	Voltage (V)	Gas flow
DCEP	100% CO ₂	150-300 (1.2mm)	23-32 (1.2mm)	20-25 L/min (1.2mm)
		200-400 (1.6mm)	24-36 (1.6mm)	20-25 L/min (1.6mm)

Packing & Ordering Information

Wire sizes	Carton Weight	Pallet Weight	Packing method
1.2mm 1.6mm	15kg	1,080kg	Vacuum packed

Notes on product application:

- Proper wind-shielding measures are advisable to avoid porosity.
- Increase voltage by 1-2V, when welding cable are more than 15 meters.
- Ensure base materials are free from moisture, dust, rust and oil before welding.

