

Dual Shield 7100SRM

Dual Shield 7100SRM is an all-position flux cored wire that displays exceptional impact properties in both the as welded and stress relieved condition when used with 75% Ar/25% CO₂ shielding. The weld deposit has less than 0.5% nickel which conforms to the A-1 composition in ASME Section IX, QW-440.

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|------------------------|---|
| Classifications | SFA/AWS A5.20 : E71T-9MJH4/T-12MJH4 SFA/AWS A5.36 : E71T1-M21-A5-CS2 H4 SFA/AWS A5.36 : E71T1-M21-P5-CS2 H4 |
| Approvals | LR 5Y40S(H5) CWB CSA W48: Class E491T-9MJ-H4 E491T-12MJ-H4 |
| Industry | Pressure Vessels Ship/Barge Building Marine and Offshore |

Approvals are based on factory location. Please contact ESAB for more information.

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|----------------------------|--------------------|
| Welding Current | DC+ |
| Diffusible Hydrogen | <4 |
| Alloy Type | C Mn Ni |
| Shielding Gas | M21 (EN ISO 14175) |

Typical Charpy V-Notch Properties

| Condition | Testing Temperature | Impact Value |
|-----------|---------------------|--------------|
| M21 | | |

Deposition Data

| Diameter | Current | Voltage | TTW Dist. |
|-----------------------|-----------|---------|--------------------|
| 1.2 mm (0.045 in.) | 135-265 A | 22-30 V | (0.4, in.) |
| 1.4 mm (0.052 in.) | 125-350 A | 23-31 V | 13.0 mm (0.5, in.) |
| 1.6 mm (1/16 in.) | 165-415 A | 25-32 V | 16.0 mm (0.6, in.) |

Recommended Welding Parameters

| Current | Wire Diameter | Voltage |
|-----------|---------------|---------|
| 140-270 A | 1.14 mm | 22-28 V |
| 140-330 A | 1.14 mm | 22-34 V |