

Dual Shield 7100 LH

DUAL SHIELD 7100 LH is a multi-purpose all positional rutile, low hydrogen cored wire for use with CO₂ or Ar/CO₂ shielding gas. The wire is suitable for all mild and medium tensile steels. The running characteristics are exceptional with a stable arc, low spatter and flat welds.

Specifications

Classifications	SFA/AWS A5.20 : E71T-1C SFA/AWS A5.20 : E71T-1M
Approvals	ABS : 3SA, 3YSA (M21 and C1) BV : SA3, SA3YM HH (M21 and C1) DNV : III YMS(H10) (M21 and C1) GL : 3YH10S (M21 and C1) LR : 3YS H5 (C1), 3YS H10 (M21) CCS : 3Y40SH10 (M21 and C1) ClassNK : KSW53G H10 (M21 and C1) JIS : T492T1-1CA-K-UH5

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

Welding Current	DC+
Alloy Type	C-Mn

Typical Tensile Properties

Condition	Conditional Statement	Yield Strength	Tensile Strength	Elongation
M21 shielding gas				
As Welded	As welded	550 MPa	600 MPa	30 %
C1 shielding gas				
As Welded	As welded	500 MPa	570 MPa	31 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
As Welded	-20 °C	72 J
C1 shielding gas		
As Welded	-20 °C	61 J

Typical Weld Metal Analysis %

C	Mn	Si
0.055	1.20	0.50

Deposition Data

Diameter	Current	Voltage
1.2 mm	150-350 A	23-35 V