Dual Shield II 71 HI

Dual Shield II 71-HI is an all-position flux cored wire designed for optimum performance when using 100% CO2 shielding gas, while producing diffusible hydrogen levels of <4 mL/100g over a wide range of welding parameters. This wire was designed to join low and medium carbon steels where higher impacts and toughness are required. Dual Shield II 71-HI has excellent welder appeal and performs well over steels with moderate rust and mill scale. The smooth metal transfer facilitates easy deposition of vertical – up stringer beads.

Classifications Weld Metal:	EN ISO 17632-A:T 42 4 P C 1 H5, KS D 7104:YFL-C504R, JIS Z 3313:T494T1-1CA-U, SFA/AWS A5.20:E71T-9C-J
Approvals:	CE EN 13479, GL 4YH5S (C1), CCS 4YSH5 (C1), LR 4YS H5 (C1), KR 4YSG H5 (C1), DNV IV YMS H5 (C1), ClassNK KSW54G(C)H5, BV SA4YM H5 (C1), ABS 4YSA H5 (C1)
Industry or Segmentation:	Marine and Offshore, Ship/Barge Building, Bridge Construction, Industrial and General Fabrication, Mobile Equipment, Pressure Vessels

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

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
C1			
As Welded	520 MPa (75.4 ksi)	585 MPa (84.8 ksi)	31 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
As Welded	-30 °C (-22 °F)	120 J (88 ft-lb)
As Welded	-40 °C (-40 °F)	110 J (81 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P	Ni
0.03	1.25	0.33	0.005	0.012	0.35

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