

PREMIUM FLUX CORED WIRE



Scan QR code
to learn more about
Washington Alloy

EAGLE-ARC 719 FLUX CORED WIRE

AWS A5.20 E71T-1C/1M, 9C/9M H8 | ASME SFA 5.20 E71T-1C/1M, 9C/9M H8

EAGLE ARC 719 is a NON-baked flux cored wire designed for single or multi pass welding having a smooth arc transfer, low spatter, flat to slightly convex bead contour, with a high deposition rate, and easy slag removal. This all-position wire has excellent feeding and low fume generation using 100% CO² or mixed gas making it a good choice for mild steel and higher strength steels.

KEY FEATURES:

- Exceptional slag removal, flat bead appearance, excellent out of position welding, versatility with either shielding gas, especially 100% CO²
- Vacuum sealed packaging to prevent moisture contamination
- Non-baked Flux Cored wire designed for single or multi pass welding
- Able to be run with either Mixed Gas or 100% CO²
- Meets Seismic Requirements of AWS D1.8
- Approvals: ABS, CWB



ORDERING INFORMATION:

- Part#: TCC EAGLE-ARC 719 --
- Diameter (Inch) available: .045, .052, 1/16
- Packaging available: 33 lb. 44 lb Spool, 550 lbs Drum

TYPICAL WELD METAL CHEMISTRY (%)

	C	Mn	Si	P	S	Cu	Ni	Mo
CO ²	0.038	1.30	0.44	0.009	0.006	0.01	0.01	0.02
Mixed	0.043	1.48	0.52	0.018	0.005	0.01	0.01	0.02

TYPICAL WELD METAL MECHANICAL PROPERTIES

	TENSILE STRENGTH	YEILD STRENGTH	ELONGATION	Impact value ft/lbs (-20°F)
CO ²	84,200 psi	73,300 psi	31%	35
Mixed	90,800 psi	80.800 psi	29%	57

SUPERFLOW 71T FLUX CORED WIRE

AWS A5.20 E71T-1C/1M, 9C/9M H8 | ASME SFA 5.20 E71T-1C/1M, 9C/9M H8

SUPERFLOW 71T is a special formulation baked flux cored wire for single or multi-pass all position welds on mild steels and 490N/mm² (71,000 psi) class high strength steels. SUPERFLOW 71T is noted for its low spatter, smooth arc and ease of slag removal. SUPERFLOW 71T has been designed to provide excellent feedability when used for all position welds of light, medium and heavy thickness plates using 75-80% Argon + balance CO² mixed shield gas, or 100% CO².

KEY FEATURES:

- All position welding property, less spatter, stable arc, thin slag
- Yields great penetration on light, medium or heavy gauge plate
- Able to run with either mixed gas or 100% CO²
- Weld deposit exhibits great tie-in with self-peeling slag
- Meets Seismic Requirements of AWS D1.8



ORDERING INFORMATION:

- Part#: TCF71T-1--
- Diameter (Inch) available: .035, .045, .052, 1/16
- Packaging available: 11 lb, 33 lb, 44 lb Spool

TYPICAL WELD METAL CHEMISTRY (%)									
	C	Mn	Si	Cr	Ni	Mo	P	S	V
CO ²	0.045	1.15	0.40	0.02	0.01	0.01	0.013	0.005	0.01
Mixed	0.050	1.20	0.45	0.02	0.01	0.01	0.012	0.005	0.01

TYPICAL WELD METAL MECHANICAL PROPERTIES				
	TENSILE STRENGTH	YEILD STRENGTH	ELONGATION	Impact value ft/lbs (-20°F)
CO ²	84,143 psi	73,310 psi	31%	35
Mixed	90,794 psi	80,786 psi	29%	57

CHOSUN CSF-71T FLUX CORED WIRE

AWS A5.20 E71T-1C/1M H8 | ASME SFA 5.20 E71T-1C/1M H8

CSF 71T is a baked flux cored wire designed for single or multi pass welding having a smooth arc transfer, low spatter, flat to slightly convex bead contour, with a high deposition rate and easy slag removal. This all-position baked wire has excellent feeding and low fume generation using 100% CO₂ or mixed gas making it a good choice for mild steel and higher strength steels.

KEY FEATURES:

- Available as baked or non-baked flux cored wire designed for single or multi pass welding
- Smooth arc transfer, low spatter, flat to slightly convex bead contour
- All-position baked wire with excellent feeding and low fume generation using Mixed Gas or 100% CO₂
- Non-baked formula listed and approved by ExxonMobil® Qualified Manufacturer List (QML)
- Excellent choice for vertical down welding
- Able to be run at high feed speeds allowing for increased deposition rate
- Meets Seismic Requirements of AWS D1.8
- Approvals: ABS, BV, DNV, KR, LR, NK



CHOSUN WELDING

ORDERING INFORMATION:

- Part#: CSF-71T --
- Diameter (Inch) available: .045, .052, 1/16
- Packaging available: 33 lb, 44 lb Spool, 550 lbs Drum

TYPICAL WELD METAL CHEMISTRY (%)

	C	Mn	Si	P	S	Cu	Ni	Mo
CO ₂	0.06	1.34	0.58	0.014	0.006	0.02	0.01	0.01
Mixed	0.06	1.41	0.64	0.015	0.005	0.02	0.01	0.01

TYPICAL WELD METAL MECHANICAL PROPERTIES

	TENSILE STRENGTH	YEILD STRENGTH	ELONGATION	Impact value ft/lbs (0°F)
CO ₂	85,400 psi	73,200 psi	31%	35.3
Mixed	91,500 psi	83.300 psi	29%	57.3

CHOSUN CSF-71LF FLUX CORED WIRE

AWS A5.20 E71T-1C/1M, 9C/9M H8 | ASME SFA 5.20 E71T-1C/1M, 9C/9M H8

CSF-71LF is a special formulation flux cored wire for single or multi-pass all position welds on mild steels and 490N/mm² (71,000 psi) class high strength steels. CSF-71LF is noted for its low spatter, smooth arc and ease of slag removal. CSF-71LF has been designed to provide excellent feed ability when used for all position welds of light, medium and heavy thickness plates using 75-80% Argon + balance CO² mixed shielding gas.

KEY FEATURES:

- All position welding property, less spatter, stable arc, thin slag
- Yields great penetration on light, medium or heavy gauge plate
- Able to run with either mixed gas or 100% CO²
- Weld deposit exhibits great tie-in with self-peeling slag
- Meets Seismic Requirements of AWS D1.8
- Approvals: ABS, BV, DNV, LR, NK



 CHOSUN WELDING

ORDERING INFORMATION:

- Part#: CSF-71LF --
- Diameter (Inch) available: .045, .052, 1/16
- Packaging available: 15 lb, 33 lb, 44 lb Spool, 550 lb drum

TYPICAL WELD METAL CHEMISTRY (%)

	C	Mn	Si	P	S	Ni	Va
CO ²	0.04	1.35	0.45	0.011	0.009	0.01	0.01
Mixed	0.04	1.45	0.50	0.012	0.011	0.01	0.01

TYPICAL WELD METAL MECHANICAL PROPERTIES

	TENSILE STRENGTH	YEILD STRENGTH	ELONGATION	Impact value ft/lbs (-20°F)
CO ²	76,852 psi	69,645 psi	32.8%	48
Mixed	88,455 psi	79,382 psi	30.5%	59

CHOSUN CSF-71SRM FLUX CORED WIRE

AWS A5.20 E71T-12MJ H8 | ASME SFA 5.20 E71T-12MJ H8

CSF-71SRM provides excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire. To be used with 490N/mm² class high strength steel and low temperature steel. Butt fillet welding of 490N/mm² class high strength steel and low temperature steel of structure such as ships, bridges, buildings and storage tanks etc, with mix Argon/CO₂ shielding gas.

KEY FEATURES:

- Baked flux cored wire designed for single or multi pass welding
- Smooth arc transfer, low spatter, flat to slightly convex bead contour
- All-position baked wire with excellent feeding and low fume generation using mixed gas
- Listed and approved by ExxonMobil® Qualified Manufacturer List (QML)
- Excellent impact toughness values at low temperatures
- CharpyV-notch at -40°F: 62 ft/lbs
- Approvals: ABS, DNV



 **CHOSUN WELDING**

ORDERING INFORMATION:

- Part#: CW71T-12MJ --
- Diameter (Inch) available: .045, 1/16
- Packaging available: 33 lb spool

TYPICAL WELD METAL CHEMISTRY (%)

	C	Mn	Si	P	S
TYPICAL	0.12	1.60	0.90	0.030	0.030

TYPICAL WELD METAL MECHANICAL PROPERTIES

	TENSILE STRENGTH	YEILD STRENGTH	ELONGATION	Impact value ft/lbs (-20°F)
TYPICAL	80,000 psi	74,400 psi	34%	95

PREMIUM 70C-6M METAL CORED WIRE

AWS A5.18 E70C-6M H4 | ASME SFA 5.18 E70C-6M H4

E70C-6M is a metal cored wire designed for single or multi pass welding on mild steels having a smooth stable arc transfer, spatter free, excellent bead contour, with a high deposition rate and nearly free of slag weld bead. This wire is formulated to weld flat and horizontal which has deoxidizers that helps where mill scale may be present. This metal cored wire may be used on many fabrications and is also found often in robotic applications.

KEY FEATURES:

- Metal cored wire designed for single or multi pass
- Formulated to weld flat and horizontal which has deoxidizers helping where mill scale may be present
- Yields very low smoke and minimal clean up
- Flat & H Fillet efficient welding with Ar+20-25% CO² shielding gas (90Ar/10CO² may also be used)
- Approvals: ABS, CWB



ORDERING INFORMATION:

- Part#: TCD 70C-6M --
- Diameter (Inch) available: .035, .045, .052, 1/16
- Packaging available: 33 lb. 44 lb Spool, 550 lbs Drum

TYPICAL WELD METAL CHEMISTRY (%)					
	C	Mn	Si	P	S
TYPICAL	0.048	1.502	0.651	0.005	0.004

TYPICAL WELD METAL MECHANICAL PROPERTIES				
	TENSILE STRENGTH	YEILD STRENGTH	ELONGATION	Impact value ft/lbs (-20°F)
CO ²	86,100 psi	77,400 psi	27%	67



Scan QR code
to learn more about
Washington Alloy

 **WASHINGTON ALLOY CO.**

825 Groves St. Lowell, NC 28098

Phone: (980) 550-2002

Toll Free: (888) 522-8296

Fax: (909) 291-4586

CALIFORNIA

MASSACHUSETTS

NORTH CAROLINA

TEXAS

WASHINGTON

Toll Free (888) 522-8296

www.weldingwire.com

Washington Alloy Co. 2023 All Rights Reserved