



**Chandraprabhu Enterprise Private Limited**

**MILD STEEL WELDING WIRES**

**Name: CEPL-102 AWS A 5.20 E71 T-1**

Weld metal chemistry (with CO2 shield)	C = 0.10% Max, S = 0.025% Max, Mn = 1.00 to 1.60%, P = 0.025% Max, Si = 0.55% Max		
Typical all weld mechanical properties (with CO2 shield)	UTS = 550N/mm <sup>2</sup> ; YS = 480N/mm <sup>2</sup> ; Elongation(%) = 22(L = 4d) min Typical charpyVnotch Impact value at -20°C = 55 Joules		
Welding position	All		
Welding parameter guidelines (with CO2 shield)	Size	Range	Recommended
	1.20mm	90-300A, 18-28V	180-300A, 22-26V(F), 100-150A, 18-22V(P)
	1.60mm	125-400A, 18-30V	220-350A, 25-30V(F), 125-200A, 18-22V(P)

*a gift to trust*