



## 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% CO<sub>2</sub> shielding. The weld deposit has less than 0.5% nickel which conforms to the A-1 composition in ASME Section IX, QW-440.

<b>Classifications</b>	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
<b>Approvals</b>	LR 5Y40S(H5) CWB CSA W48: Class E491T-9MJ-H4 E491T-12MJ-H4
<b>Industry</b>	Pressure Vessels Ship/Barge Building Marine and Offshore

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

<b>Welding Current</b>	DC+
<b>Diffusible Hydrogen</b>	<4
<b>Alloy Type</b>	C Mn Ni
<b>Shielding Gas</b>	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