

Dual Shield 7000-A1

Dual Shield 7000-A1 is an all-position flux cored electrode recommended for 0.5% Mo steels. It is used in the fabrication and erection of boilers, pressure piping and tubing and other pressure vessel applications. Shielding gas of 100% CO₂ and 75% Ar, remainder CO₂ may be used. The weld metal analysis is similar to an E7018-A1 low hydrogen electrode.

Classifications	AWS A5.29 : E81T1-A1C/A1M AWS A5.36 : E81T1-C1AZ-A1 AWS A5.36 : E81T1-C1PZ-A1 ASME SFA 5.36 ASME SFA 5.29
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Deposition Data

Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate	TTW Dist.	Deposition Efficiency %
100% CO₂						
1.2 mm (.045 in.)	140 A	24 V	508 cm/min (200 in./min)	1.7 kg/h (3.6 lb/h)	15.9 mm (5/8 in.)	77.8 %
1.2 mm (.045 in.)	192 A	25.5 V	762 cm/min (300 in./min)	2.5 kg/h (5.5 lb/h)	15.9 mm (5/8 in.)	79.3 %
1.2 mm (.045 in.)	230 A	27 V	1016 cm/min (400 in./min)	3.3 kg/h (7.4 lb/h)	19 mm (3/4 in.)	81.8 %
1.2 mm (.045 in.)	275 A	28.5 V	1270 cm/min (500 in./min)	4.4 kg/h (9.6 lb/h)	19 mm (3/4 in.)	83.1 %
1.4 mm (.052 in.)	150 A	23.5 V	381 cm/min (150 in./min)	1.6 kg/h (3.6 lb/h)	19 mm (3/4 in.)	75.8 %
1.4 mm (.052 in.)	190 A	24 V	508 cm/min (200 in./min)	2.2 kg/h (4.9 lb/h)	19 mm (3/4 in.)	77.8 %
1.4 mm (.052 in.)	250 A	25.5 V	762 cm/min (300 in./min)	3.5 kg/h (7.7 lb/h)	19 mm (3/4 in.)	81.7 %
1.4 mm (.052 in.)	300 A	27 V	1016 cm/min (400 in./min)	4.7 kg/h (10.3 lb/h)	19 mm (3/4 in.)	82.5 %
1.4 mm (.052 in.)	345 A	28.5 V	1270 cm/min (500 in./min)	6.0 kg/h (13.3 lb/h)	19 mm (3/4 in.)	84.7 %
1.6 mm (1/16 in.)	195 A	24 V	381 cm/min (150 in./min)	2.5 kg/h (5.5 lb/h)	19 mm (3/4 in.)	85 %
1.6 mm (1/16 in.)	290 A	25.5 V	635 cm/min (250 in./min)	4.2 kg/h (9.2 lb/h)	19 mm (3/4 in.)	86.5 %
1.6 mm (1/16 in.)	325 A	26.5 V	762 cm/min (300 in./min)	4.9 kg/h (10.9 lb/h)	19 mm (3/4 in.)	85.9 %
1.6 mm (1/16 in.)	352 A	27 V	889 cm/min (350 in./min)	6.0 kg/h (13.1 lb/h)	19 mm (3/4 in.)	88.1 %
1.6 mm (1/16 in.)	382 A	28.5 V	1016 cm/min (400 in./min)	6.7 kg/h (14.7 lb/h)	19 mm (3/4 in.)	86.8 %