



# Dual Shield 7100 Ultra

FCAW

ESAB Dual Shield 7100 Ultra is an all-position flux cored wire designed for optimum performance when using 100% CO<sub>2</sub> shielding. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. Fillet contour is flat, slightly convex with equal leg length and uniform sidewall wetting. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness.

## Welding Current

DC (+)

## Shielding Gas

CO<sub>2</sub> or Argon/CO<sub>2</sub>

PACKING/ORDERING INFORMATION			
Part Number	Dia (mm)	Carton Weight (kg)	Pallet Weight (kg)
35RU122470	1.2	15	945
35RU142470	1.4	15	945
35RU162470	1.6	15	945
VacPac			
35RU12247V	1.2	15	945
35RU14247V	1.4	15	945
35RU16247V	1.6	15	945

CLASSIFICATIONS	APPROVALS		TYPICAL ALL WELD METAL COMPOSITION (%)		TYPICAL MECH. PROPERTIES ALL WELD METAL	
			Gas	CO <sub>2</sub>	Yield Stress, Mpa	
<u>SFA/AWS A5.20</u> E71T-1/E71T-9J	ABS	3SA, 3YSA H10	C	0.05	495	
	LR	3S, 3YS H10	Mn	1.32		<u>Tensile Strength, Mpa</u>
	DNV	III YMS (H10)	Si	0.40	561	
	BV	SA3YM HH	P	0.013		<u>Elongation, %</u>
	GL	3YH10S	S	0.007	31	
	NK	KSW 53G (C/M2) H10	Ni	0.45		<u>Charpy V</u>
	KR	RSW 53G HH				Test Temps, °C    Impact Values, J
						-18                    155
					-29                    134	
					-40                    105	

