



**DATA SHEET**  
**DS 173**  
**Rev. 6 dd 24/01/2017**  
**INETUB BA71TGS**

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**CLASSIFICATION**

AWS SPECIFICATIONS	EN ISO SPECIFICATIONS
AWS A 5.20: E71T-GS	EN ISO 17632-A: T 42 Z W N 1 H15
AWS A 5.20M: E491T-GS	
ASME SFA 5.20: E71T-GS	
ASME SFA 5.20M: E491T-GS	

**APPROVALS**


**ALLOY TYPE**

Self-shielded flux cored wire for welding carbon and carbon-manganese steels.

**APPLICATIONS**

Open-arc flux cored wire (self-shielded) designed for welding thin carbon and carbon-manganese steels in all positions. Easily removable slag, versatility and manuality; suitable for welding zinc-coated plates as well. Applications include tanks, boilers, steel structural works (large thickness), earthworks and construction works. To be used on DC- (DC operation, electrode negative polarity).

**MATERIALS TO BE WELDED**

ASTM		EN		Others
A 131 Gr A, B, D		10025 Gr S185	10028-2 P355 G H	
A 131 AH32 to DH36		10025 Gr S235	10113-2 S275	
API 5LX		10025 Gr S275	10113-2 S355	
		10025 Gr S355	10113-3 S275	
		10028-2 P235 G H	10113-3 S355	
		10028-2 P265 G H		
		10028-2 P295 G H		

**WELDING GUIDELINES**

Preheat and PWHT are not required.

**TECHNICAL INFORMATION**

Gas: open-arc  
Welding positions: all positions



**WELDING PARAMETERS**

Current	DC - Straight polarity				
	0.8	0.9	1.0	1.2	
Diameter (mm)					
Volts (V)	18 ÷ 21	19 ÷ 23	19 ÷ 24	19 ÷ 25	
Intensity (A)	100 ÷ 130	110 ÷ 150	120 ÷ 170	150 ÷ 220	



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**TYPICAL CHEMICAL COMPOSITION OF WELD METAL**

GAS	C %	Mn %	Si %	S %	P %	Cu %	Ni %	Cr %	Al
open-arc	0.18	1.10	0.42	0.008	0.012	-	-	-	0.90

**TYPICAL MECHANICAL PROPERTIES**

GAS		Yield strength	Tensile strength	Elongation on % 5d	Impact energy (Charpy V)				
		Rs	Rm	A 5d	+ 20°C	0°C	-20°C	-30°C	-40°C
		(MPa)	(MPa)	%	(Joule)	(Joule)	(Joule)	(Joule)	(Joule)
open-arc	as welded	470	570	24	-	-	-	-	-

**PRODUCTS AVAILABLE**

Process	Product	Classification AWS	Classification EN
MIG/MAG Solid wire			
TIG Rods			
SAW Submerged arc			
FCAW Cored wire	INETUB BA71T11 INETUB S71TGS INETUB S71T11	AWS A 5.20: E71T-11 AWS A 5.20: E71T-GS AWS A 5.20: E71T-11	EN 17632-A: T 42 Z W N EN 17632-A: T 42 Z W N EN 17632-A: T 42 Z W N
SMAW Electrodes			