



WELDING CONSUMABLES FLUX CORE MIG WIRE E71T-1C

XCEL-ARC XFC-72

CO2 GAS SHIELDED FLUX CORE MIG WIRE
AWS A5.20 E71T-1C
AWS D1.8/D1.8M:2009 Seismic Approval



Features

- Vacuum Sealed Foil Bag
- Precision Layer Wound
- Smooth Arc Transfer
- Low Spatter
- Designed for CO²
- Smooth Bead Appearance
- Fast Freezing Slag
- All Position Welding
- International Approvals
ABS - BV - DNV - Loyds Register - NK

Typical Applications:

Structural fabrication - General Fabrication - Transport Industry Shipbuilding - Off Shore Applications - Heavy Equipment
Farm Machinery - Bridge Construction

Application Notes:

XFC-72 is a rutile flux cored wire designed for all positional welding on Mild and High Tensile steels. XFC-72 features a lower spatter and fume emissions than conventional products in its class. XFC-72 shows excellent welding performance, a soft and stable arc, low spatter loss, easy slag removal, beautiful weld appearance and high X-ray quality. This flux core wire is intended for single and multiple pass welding of carbon and certain low alloy steels and is suitable in all-positions. XFC-72 flux core wire is classified with CO² shielding gas by this specification and meets seismic approval under AWS D1.8/D1.8M:2009. XFC-72 is characterised by a spray transfer, low spatter loss, flat to slightly convex bead configuration, and a moderate volume of slag which completely covers the weld bead. Superb weld ability in all positions makes XFC-72 a good choice for general plate fabrication, structural steel welding, shipbuilding, steel fabrication and any instance where lower fume and spatter emissions are required. The reduced spatter is especially attractive in those operations where painting is performed after welding.

Chemical Composition %

≤C 0.12 ≤Si 0.90 ≤Mn 1.75 ≤P 0.03 ≤S 0.003 ≤Cu 0.35 ≤Ni 0.50 ≤Cr 0.20 ≤Mo 0.30 ≤V 0.08

Typical Mechanical Properties of Weld metal

Yield Strength	Tensile Strength	Elongation	Impact Values	Test Temperature
483 MPa	490-670 MPa	29.0%	115 J	-20°C

Usage Notes:

1. DCEP
2. Pure CO₂ Gas
3. Increase voltage by 1-2 volts when welding cable length is greater than 15 metres
4. Proper storage is required once packaging is opened

Recommended Weld Parameters:

Volts: 23-30 Amps: 150-300 Stick Out: 15-25mm Gas Flow: 20-25 l/min

Part-No	Description	Spool Weight
XFC721215	Xcel-Arc E71T-1C CO ₂ Flux Core Wire 15kg x 1.2mm	15kg
XFC721615	Xcel-Arc E71T-1C CO ₂ Flux Core Wire 15kg x 1.6mm	15kg