

## 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>	3.8
<b>Alloy Type</b>	C Mn Ni
<b>Shielding Gas</b>	M21 (EN ISO 14175)

### Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
M21 shielding gas			

### Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
M21 shielding gas		
PWHT	-40 °C (-40 °F)	110 J (81 ft-lb)
PWHT	-46 °C (-51 °F)	95 J (70 ft-lb)
PWHT	-51 °C (-60 °F)	65 J (48 ft-lb)
As Welded	-40 °C (-40 °F)	130 J (96 ft-lb)
As Welded	-46 °C (-51 °F)	110 J (81 ft-lb)
As Welded	-51 °C (-60 °F)	90 J (67 ft-lb)

### Recommended Welding Parameters

Wire Diameter	Current	Voltage
1.2 mm (0.045 in.)	-	-
1.6 mm (1/16 in.)	170-460 A	24-36 V
1.6 mm (1/16 in.)	160-280 A	24-28 V