

Crown E 71T-GS

Self-Shielded Flux Cored Arc Welding
(FCAW-S)

Carbon Steel

DCEN
All Position



Superior Carbon Steel Self-Shielded Flux-Cored Electrode

Typical Applications

Crown E 71T-GS is a self-shielded flux-cored electrode designed for the semi-automatic and automatic welding of thin-gauge galvanized and carbon steel. It is recommended for single pass welding only in all positions using no shielding gas. **Crown E 71T-GS** is not recommended for welding steel sections thicker than 3/16 inches. The arc action is smooth and stable, excellent at low welding currents. Good wetting action makes the **Crown E 71T-GS** well suited for the lap and butt joint welds encountered in body panel and sheet metal duct work. Bead geometry and appearance are excellent even when welding in the vertical down position. Spatter levels are very low. This alloy is very well suited for use in portable welding systems, as the smaller diameters perform well on portable 110 volt input welding machines. No external shielding gas is required either.

Specifications

AWS A 5.20/A5.20M
E 71T-GS

- Tensile Strength 84,500 psi (Crown E 71T-GS)
72,000 psi (AWS minimum requirement)
- Longitudinal Guided Bend Acceptable

Procedure

Use **DC straight polarity (DCEN)**. This setting will facilitate the welding of sections as thin as 18 gauge (3/64") with no burn through. Suggested welding parameters are as follows:

Flat and Horizontal positions

Diameter	Electrode Stickout (inches)	Welding Current (amps)	Arc Voltage (volts)	Wire Feed Speed (ipm)	Optimum Parameters		
					amps	volts	WFS (ipm)
.030	3/8 to 1/2	25 – 200	14 – 18	55 – 565	125	16	225
.035	3/8 to 1/2	50 – 225	13 – 19	65 – 465	150	18	250
.045	3/8 to 3/4	75 – 250	15 – 19	65 – 290	200	17	190

Vertical Up and Overhead

Diameter	Electrode Stickout (inches)	Welding Current (amps)	Arc Voltage (volts)	Wire Feed Speed (ipm)	Optimum Parameters		
					amps	volts	WFS (ipm)
.030	3/8 to 1/2	25 – 150	14 – 17	80 – 300	100	15	170
.035	3/8 to 1/2	75 – 175	13 – 19	52 – 300	150	18	250
.045	3/8 to 3/4	100 – 200	16 – 18	80 – 190	175	17	160

Sizes and Part Numbers

Diameter	Part Numbers		
	2 lb (4") Spools	8" Spools	30 lb Spools
.030	MS71GS/1E	MS71GS/2E	MS71GS/3E
.035	MS71GS/1F	MS71GS/2F	MS71GS/3F
.045	MS71GS/1G	MS71GS/2G	MS71GS/3G



!!!! WARNING !!!!



WELDING FUMES AND GASES CAN BE DANGEROUS TO YOUR HEALTH.

BEFORE USING THIS PRODUCT THE WELDER (END-USER) MUST READ AND UNDERSTAND THE COMPLETE PRODUCT WARNING LABEL AND THE NEW 16 SECTION SAFETY DATA SHEET (SDS).

THE SAFETY DATA SHEET (SDS) WHICH OUTLINES THE POTENTIAL HEALTH HAZARDS AND SAFETY INFORMATION RELATED TO THIS PRODUCT CAN BE DOWNLOADED FROM THE SDS PORTION OF THIS WEBSITE. IT IS ALSO AVAILABLE FROM YOUR EMPLOYER AND WELDING SUPPLY DISTRIBUTOR.

DO NOT PROCEED WITH USE OF THIS PRODUCT UNTIL YOU READ AND UNDERSTAND THE SAFETY DATA SHEET (SDS) AND PRODUCT WARNING STATEMENT.

BE SURE TO CONSULT THE LATEST VERSION OF THE SDS.

SEE THE PRODUCT WARNING LABEL AND SDS FOR COMPLETE WARNING INFORMATION.

