

TECHNICAL
DATA SHEET



**Dual Shield 710X-M Gas-Shielded Flux-Cored
Wires (FCAW) Mild Steel Wires**

Art. No. 984.245019807

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**Dual Shield 710X-M Mild Steel
Welding Wire** Art. No. 984.245019807

PRODUCT DESCRIPTION

Dual Shield 710X-M provides outstanding operator appeal with an easily controlled arc, improved operation at both lower and higher current levels, minimal spatter and easily removed slag. Dual Shield 710X-M is designed to be used with 75/25 Argon CO2 gas mix.

Classifications	AWS A5.20 : E71T-1MD-H8/T-9MD-H8 AWS A5.36 : E71T1-M21A4-CS1-DH8 ASME SFA 5.36 ASME SFA 5.20
Approvals	Seismic Certified "D" ABS CWB CSA W48 E491T-9M-H8 DNV-GL LR MILE-24403A 71T-1M
Industry	Barges Civil Construction Industrial and General Fabrication Railcars Ship/Barge Building Light Equipment

Approvals are based on factory location. Please contact ESAB for more information.

Typical Tensile Properties

Condition	Yield Strength	Tensile Strength	Elongation
75% Ar - 25% CO2			
As Welded	510 MPa (74 ksi)	570 MPa (83 ksi)	29 %

Typical Charpy V-Notch Properties

Condition	Testing Temperature	Impact Value
75% Ar - 25% CO2		
As Welded	-18 °C (0 °F)	97 J (72 ft-lb)
As Welded	-29 °C (-20 °F)	76 J (56 ft-lb)

Typical Weld Metal Analysis %

C	Mn	Si	S	P
0.04	1.3	0.5	0.008	0.012

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Deposition Data

75% Ar - 25% CO ₂						
Diameter	Current	Voltage	Wire Feed Speed	Deposition Rate	TTW Dist.	Deposition Efficiency %
1.2 mm (.045 in.)	290 A	-	1143 cm/min (450 in./min)	4.05 kg/h (8.92 lb/h)	25.4 mm (1 in.)	87 %
1.2 mm (.045 in.)	270 A	29 V	1016 cm/min (400 in./min)	3.70 kg/h (8.17 lb/h)	25.4 mm (1 in.)	87 %
1.2 mm (.045 in.)	250 A	29 V	889 cm/min (350 in./min)	3.21 kg/h (7.08 lb/h)	25.4 mm (1 in.)	86 %
1.2 mm (.045 in.)	230 A	27 V	762 cm/min (300 in./min)	2.66 kg/h (5.86 lb/h)	19 mm (3/4 in.)	84 %
1.2 mm (.045 in.)	210 A	27 V	635 cm/min (250 in./min)	2.22 kg/h (4.90 lb/h)	19 mm (3/4 in.)	86 %
1.2 mm (.045 in.)	190 A	26 V	508 cm/min (200 in./min)	1.75 kg/h (3.85 lb/h)	12.7 mm (1/2 in.)	85.5 %
1.2 mm (.045 in.)	150 A	26 V	381 cm/min (150 in./min)	1.28 kg/h (2.82 lb/h)	12.7 mm (1/2 in.)	79 %
1.4 mm (.052 in.)	370 A	32 V	1270 cm/min (500 in./min)	5.55 kg/h (12.23 lb/h)	25.4 mm (1 in.)	86 %
1.4 mm (.052 in.)	360 A	32 V	1143 cm/min (450 in./min)	5.01 kg/h (11.05 lb/h)	25.4 mm (1 in.)	87 %
1.4 mm (.052 in.)	350 A	32 V	1016 cm/min (400 in./min)	4.44 kg/h (9.80 lb/h)	25.4 mm (1 in.)	86 %
1.4 mm (.052 in.)	340 A	30 V	889 cm/min (350 in./min)	3.92 kg/h (8.65 lb/h)	19 mm (3/4 in.)	86 %
1.4 mm (.052 in.)	310 A	30 V	762 cm/min (300 in./min)	3.33 kg/h (7.35 lb/h)	19 mm (3/4 in.)	86 %
1.4 mm (.052 in.)	260 A	30 V	635 cm/min (250 in./min)	2.72 kg/h (6.00 lb/h)	19 mm (3/4 in.)	86 %
1.4 mm (.052 in.)	220 A	28 V	508 cm/min (200 in./min)	2.20 kg/h (4.86 lb/h)	15.8 mm (5/8 in.)	84.5 %
1.4 mm (.052 in.)	190 A	28 V	381 cm/min (150 in./min)	1.66 kg/h (3.66 lb/h)	15.8 mm (5/8 in.)	83 %
1.6 mm (1/16 in.)	480 A	32 V	1143 cm/min (450 in./min)	7.33 kg/h (16.17 lb/h)	31.75 mm (1 1/4 in.)	87 %
1.6 mm (1/16 in.)	430 A	32 V	1016 cm/min (400 in./min)	6.49 kg/h (14.33 lb/h)	31.75 mm (1 1/4 in.)	87 %
1.6 mm (1/16 in.)	420 A	32 V	889 cm/min (350 in./min)	5.72 kg/h (12.63 lb/h)	31.75 mm (1 1/4 in.)	86.5 %
1.6 mm (1/16 in.)	360 A	30 V	635 cm/min (250 in./min)	4.85 kg/h (10.70 lb/h)	25.4 mm (1 in.)	86 %
1.6 mm (1/16 in.)	360 A	30 V	635 cm/min (250 in./min)	4.04 kg/h (8.90 lb/h)	25.4 mm (1 in.)	86 %
1.6 mm (1/16 in.)	300 A	28 V	508 cm/min (200 in./min)	3.21 kg/h (7.08 lb/h)	19 mm (3/4 in.)	85.5 %
1.6 mm (1/16 in.)	250 A	28 V	381 cm/min (150 in./min)	2.37 kg/h (5.23 lb/h)	19 mm (3/4 in.)	85 %

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2021

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