K-71TLF

For 490MPa high tensile steel

Classifications

EN ISO 17632-A:2008	: T46 2 P C 1 H5	AWS A5.20-05	: E71T-1C/-1M
	: T46 2 P M 1 H10	AWS A5.36-12	: E71T1-C1A0- CS1-H4
EN ISO 17632-B:2008	: T49 2 T1-1CA-U H5		: E71T1-M21A0- CS1-H8
	: T49 2 T1-1MA-U H10	KS D 7104	: YFW-C(A)50DR
JIS Z 3313	: T49 2 T1-1CA H5		
	: T49 2 T1-1MA-U H10		

Description

- It is designed for welding of 490MPa high tensile steel with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a titania type of flux cored wire for all-position welding general fabrications
- It provides low fume generation and has good impact strength at low temperatures
- It also provides excellent usability with stable arc, less spatter levels, smooth bead shape

Welding positions

Polarity & shielding gas

- CO_2: 100% CO_2,
  Mix: Ar+20% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
CO_2	0.03	0.38	1.35	0.015	0.010

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20℃	IV (J) -30℃	Remarks
AWS A5.20	min. 390	490~670	min. 22	≥ 27		
EN ISO 17632-B	min. 390	490~670	min. 18	≥ 47		
Example	520	570	28	80	50	CO_2

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input
- When you use to Ar+CO_2 mixture gas, you should be lower 1~2 voltage than 100% CO_2 gas

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		

Approvals

Shielding gas	ABS	BV	DNV	CCS	LR	NK	KR
CO_2	3YSAH10	3S3YSH10	||| YMS(H10)	3S3YSH10	3YSH10	KSW53GH10	3YSGH10