

Flux Cored Wire
K-71TLF



KISWEL

高麗熔接棒

K-71TLF

AWS A5.20 E 71T-1
EN 758 T 462RC1
JIS Z3313 YFW-C50DR
AS. 2203.1: ETP-GCP-W503A. CM1
QS 9000, ISO 9002 CERTIFICATE No:945224.
ISO 14001 CERTIFICATE No:K992005.

For carbon steel

Typical applications

Butt and fillet welding of mild steel and 490N/mm² class high tensile strength steel for machinery, cars, shipbuildings and bridges, etc.

Characteristics on Usage

- ① Good working efficiency.
- ② Little fume generation other than the same grade.
- ③ Excellent feedability.
- ④ Stable arc and lowspatter generation.
- ⑤ Usability in all positions.

Typical chemical composition of all-weld-metal (%)

Shielding Gas	C	Si	Mn	P	S
CO ₂	0.03	0.30	1.45	0.015	0.010

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	El. (%)	Charpy V-notch I.V J {kgf · m}
CO ₂	510 {52}	550 {56}	28	60 {6} (-18℃)

Sizes available and recommended currents (DC ⊕)

Dia. (mm)		1.0	1.2	1.6
Amp.	F	80 ~ 260	120 ~ 300	200 ~ 450
	H-fillets	80 ~ 260	120 ~ 300	200 ~ 400
	V	80 ~ 200	120 ~ 250	180 ~ 220

Approval : ABS, BV, DNV, GL, KR, LR, NK, TÜV, CCS, JIS

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