K-71T

For 490MPa high tensile steel

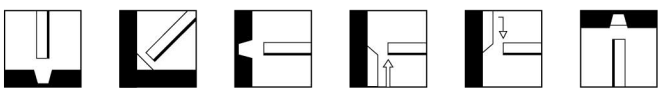
Classifications

EN ISO 17632-A:2008	: T46 0 P C 1 H10	KS D 7104	: YFW-C50DR
EN ISO 17632-B:2008	: T49 0 T1-1CA-U H10	JIS Z 3313	: T49J 0 T1-1CA-U H10
AWS A5.20-07	: E71T-1C		

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
- It feature excellent mechanical properties, easy slag removal, low spatter generation, smooth bead shape, high X-ray safety

Welding positions



Polarity & shielding gas

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

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
CO_2	0.04	0.55	1.25	0.015	0.011

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 0℃	IV (J) -20℃	Remarks
AWS A5.20	min. 390	430~600	min. 22		≥ 27	
EN ISO 17632-B	min. 390	430~600	min. 20	≥ 47		
Example	520	580	29	70	55	CO_2

Notes on usage and welding condition

- Refer to page 185~187 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

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	RINA
CO_2	2YSAH10	SA2YM	