

Flux Cored Welding Wire

K-71TLF

For 490MPa high tensile steel

Classifications

EN ISO 17632-A:2008	: T46 2 P C/M 1 H5	KS D 7104	: YFW-C/A502R
EN ISO 17632-B:2008	: T49 2 T1-1C/MA-U H5	JIS Z 3313	: T49 2 T1-1C/MA-U H10
AWS A5.20-07	: E71T-1C/-1M		

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 provide excellent usability with stable arc, less spatter levels, smooth bead shape

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂,
- Mix: Ar+20% CO₂ (15~25 ℓ/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)		Shielding gas
				-20°C	-30°C	
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 191~193 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+CO₂ mixture gas, you should be lower 1~2 voltage than 100% CO₂ 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	GL	LR	NK	KR
CO ₂	3YSAH10	3S3YSH10	III YMS(H10)	3YH10S	3Y10SH5	KSW53GH10	3YSGH10

* Others : RINA, CWB, TUV, DB, CE, JIS, KS