

K-71TLF

For 490MPa high tensile steel

Classifications

EN ISO 17632-A:2015	: T 42 2 P C1 1 H5	AWS A5.20-2005(R2015)	: E71T-1C/-1M
	: T 46 2 P M21 1 H10	AWS A5.36-2016	: E71T1-C1A0-CS1-H4
EN ISO 17632-B:2015	: T 49 2 T1-1C1A-U H5		: E71T1-M21A0-CS1-H8
	: T 49 2 T1-1M21A-U H10		
JIS Z 3313-2009	: T 49 2 T1-1C/M A-U H10	KS D 7104-2012	: YFW-C(A)50DR

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 titania type of flux cored wire for all-position welding.
- It provides low fume generation and has good impact strength at low temp.



Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15 – 25 l/min)
- 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)		Remarks
				-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 KISWEL welding handbook page 219-221 for more information on usage.
- For Mix gas, voltage should be lowered by 1-2 volts compared to when you weld with 100% CO₂

Package

Diameter (mm)	1.2, 1.4, 1.6
Spool (kg)	5, 12.5, 15, 20
Pailpack (kg)	100 - 300

Approvals

ABS	BV	DNV GL	LR	KR	NK
3YSA H10	3S, 3YS, H10	III YMS(H10)	3YS H15	3YSG(C)H10	KSW53G (C)H10

*Others: CWB, JIS, TUV, DB