

K-71UT

For 490MPa low temperature service steel

Classifications

EN ISO 17632-A:2015	: T 42 4 P C1 1 H5	AWS A5.20-2005(R2015)	: E71T-9CJ H4
EN ISO 17632-B:2015	: T 49 4 T1-1C1 A-U H5	AWS A5.36-2016	: E71T1-C1A4-CS1-H4
JIS Z 3313-2009	: T 49J 4 T1-1C A-U H5	KS D 7104-2012	: YFL-C50 4R

Description

- It is designed for welding of 490MPa low temperature steels.
- Typical applications include railcars, automotive machinery, shipbuilding, bridges, heavy equipment etc.
- Wire is titania type of flux cored wire for all-position welding.
- It features excellent mechanical properties, easy slag removal, low spatter generation and good impact at low temperature down to -40 °C.



Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15 – 25 l/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding Gas	C	Si	Mn	P	S	Ni
CO ₂	0.04	0.30	1.35	0.014	0.010	0.39

Typical mechanical properties of all-weld metal

	Y.S. (MPa)	T.S. (MPa)	El. (%)	IV (J)		Remarks
				-30 °C	-40 °C	
AWS A5.20	Min. 390	490-670	Min. 22		≥ 27	
EN ISO 17632-B	Min. 390	490-670	Min. 18		≥ 47	
Example	540	600	27	76	55	CO ₂

Notes on usage and welding condition

- In order to prevent crack at low temperatures, preheat and maintain Interpass temperature at 100 – 200 °C.
- Refer to KISWEL welding handbook page 219-221 for more information on usage.

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
4YSA, 4Y400SA H5	S4Y40H5	IV Y40MS(H5)	4Y40S H10

*Others: JIS