

K-71T

AWS E71T-1
JIS YFW-C50DR
KS YFW-C50DR

**FOR HIGH TENSILE
STRENGTH STEEL**

Typical applications

K-71T is designed for welding of 490MPa high tensile steel with slow freezing slag system. Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② It features excellent mechanical properties, easy slag removal, low spatter loss smooth bead surface, high X-ray safety.
- ③ K-71T has very efficient welding due to higher deposition rate particularly.
- ④ The shielding gas should be used 100%CO₂ for welding.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	P	S
CO ₂	0.04	0.45	1.30	0.015	0.012

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 J {kgf · m}(-20℃)
CO ₂	520 {53}	580 {59}	29	50 {5}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
F		120~300	200~400
H		120~300	200~400
V		120~250	180~220

Package

Dia.	(mm)	1.2	1.4	1.6
Spool	(kg)	5, 12.5, 15, 20		
Pailpack	(kg)	100~300		

Welding positions



Approved by

ABS, BV, CCS, CWB, DNV, GL, KR, LR, NK, RINA, JIS, KS