

**K-71TB**
**AWS E71T-5/-5M**  
**JIS YFW-A502B**  
**KS YFW-A502B**
**FOR HIGH TENSILE  
STRENGTH STEEL**

### Typical applications

K-71TB is designed for the semi-automatic welding of carbon steels, and for the welding of higher strength steels in applications where the risk of hydrogen-induced cracking is to be avoided.

### Characteristics on Usage

- ① Wire is a basic slag type flux cored wire provided low crack sensitivity on certain problem steels.
- ② It has excellent CVN impact properties at sub-zero temperatures.
- ③ It provides good arc stability, low spatter generation, high efficiency, good bead.
- ④ The shielding gas should be used 100%CO<sub>2</sub> or Ar+20~25%CO<sub>2</sub> 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 <sub>2</sub>	0.02	0.60	1.60	0.015	0.013

### Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	T · S N/mm <sup>2</sup> {kgf/mm <sup>2</sup> }	El (%)	Charpy V-notch J {kgf · m} (-30°C)
CO <sub>2</sub>	550 {59}	610 {63}	30	50 {5}

### Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2
Amp.	F	160~300
	H	160~320
	V	160~240

### Package

Dia.	(mm)	1.2	1.4	1.6
Spool	(kg)	5, 12.5, 15, 20		

### Welding positions



Approved by