

FOR HIGH TENSILE
STRENGTH STEEL

AWS E71T-1/-1M
JIS YFW-C502R
KS YFW-C502R

K-71TLF

Typical applications

K-71TLF is formulated for welding of 490MPa high tensile steel with outstanding mechanical properties. 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 provides low fume generation and has good impact strength at low temperatures
- ③ It also provides excellent usability with stable arc, less spatter levels, better bead appearance as the same as that of a solid wire.
- 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	0.03	0.38	1.35	0.015	0.010

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 }	EI (%)	Charpy V-notch J {kgf · m} (-20°C)
CO ₂	520 {53}	570 {58}	28	80 {8}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F	120~300	200~450
	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, DNV, GL, KR, LR, NK, RINA, TÜV, JIS, KS
(80%Ar+20%CO₂:ABS, BV, DNV, GL, LR, TÜV)