

K-71TM

AWS E71T-1M
JIS YFW-A502R
KS YFW-A502R

**FOR HIGH TENSILE
STRENGTH STEEL**

Typical applications

K-71TM is designed for welding of 490MPa high tensile steel with only Ar/CO₂ mixtures. 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 soft welding arc and less spatter levels due to the usage of mixture gas.
- ③ K-71TM has very efficient welding due to higher deposition rate particularly.
- ④ The shielding gas should be used Ar+20~25%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
Ar+20%CO ₂	0.03	0.59	1.44	0.013	0.014

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℃)
Ar+20%CO ₂	500 {51}	520 {58}	28	80 {8}

Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F	120~300	200~400
	H-Fil		
	V-up	120~220	180~240

Package

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

Welding positions



Approved by

ABS, BV, DNV, LR, RINA, TÜV, JIS, KS