K-71TM ^{AW} JIS KS

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 \sim 25%CO₂ for welding.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	С	Si	Mn	Р	S
Ar+20%CO2	0.03	0.59	1.44	0.013	0.014

Typical mechanical properties of all-weld-metal

Shielding Gas	Y · P N/mm²{kgf/mm²}			Charpy V-notch J {kgf · m} (-20℃)
Ar+20%CO2	500 {51}	520 {58}	28	80 {8}

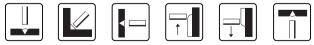
Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F H-Fil	120~300	200~400
	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