

K-71TSR

AWS E71T-12CJ H4
JIS YFL-C504R
KS YFL-C504R

FOR LOW TEMPE
 RATURE SERVICE STEEL

Typical applications

K-71TSR can be used in a variety of applications including railcar, automotive machinery, shipbuilding, bridges, heavy equipment etc. (NACE/API steel)All position for 0.4%Ni alloyed flux cored arc welding wire with 100%CO₂ shielding gas.

Characteristics on Usage

- ① Wire is a titania type flux cored wire applicable for all-position welding.
- ② It is applicable to use 490MPa class tensile strength steel welding.
- ③ It provides excellent int low temperature down to -40°C in the as-welded as well as PWHT conditions.
- ④ K-71TSR has easy slag removal, good weld sounpact value adness, low spatter generation.
- ⑤ Refer to page 150 for more information on usage.

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

Shielding Gas	C	Si	Mn	P	S	Ni
CO ₂	0.021	0.45	1.41	0.014	0.013	0.41

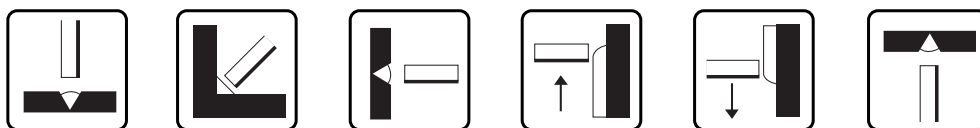
Typical mechanical properties of all-weld-metal

PWHT	Y · P N/mm ² {kgf/mm ² }	T · S N/mm ² {kgf/mm ² }	EI (%)	Charpy V-notch J {kgf · m} (-40°C)
As welded	578 {59}	612 {63}	25	119 {12}
620°C X2hr.	558 {57}	600 {61}	27	52 {5}

Sizes available and recommended currents (DC wire⊕)

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

Welding positions



Approved by

ABS, BV, DNV, GL, KR, LR, NK