

FOR ATMOSPHERIC
CORROSION RESISTING STEEL

AWS E81T1-W2
JIS YFA-50W
KS YFA-50W

K-71TW

Typical applications

K-71TW is formulated for butt or fillet MAG welding of mild and 490MPa weather-proof steels

(ASTM A67 Gr. 1; A234 Gr. WPR; A242 all; A333 Gr. 3,7; A423 Gr. 1; A588 Gr. all; A606 Gr. all; A690 Gr. all; A709 Gr. 70W; A871)

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② The weld metal contains Cr, Ni, Cu alloys and has good weather-proof properties.
- ③ It features excellent mechanical properties, easy slag removal, low spatter loss, smooth bead surface, high X-ray safety.
- 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	Cr	Ni	Cu
CO ₂	0.05	0.54	1.10	0.55	0.45	0.42

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} (-30°C)
CO ₂	510 {52}	590 {60}	28	40 {4}

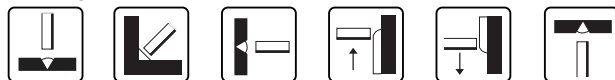
Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F	120~350	200~450
	H-Fil	120~350	200~400
	V	120~220	180~240

Package

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

Welding positions



Approved by