

FOR LOW TEMPERATURE SERVICE STEEL

AWS E71T-1/-9J
JIS YFL-C504R
KS YFL-C504R

K-71UT

Typical applications

K-71UT is designed for welding of 490MPa low temperature steels with slow freezing slag system. It can be used in a variety of applications including railcar, automotive, machinery, shipbuilding, bridges, heavy equipment etc.

Characteristics on Usage

- ① Wire is a titania type of flux cored wire for all-position welding.
- ② It has good impact value at low temperatures down to -40°C
- ③ K-71UT features easy slag removal, good weld soundness, low spatter generation.
- 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	Ni
CO ₂	0.04	0.30	1.35	0.013	0.012	0.39

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} (-40°C)
CO ₂	540 {55}	600 {61}	27	55 {5}

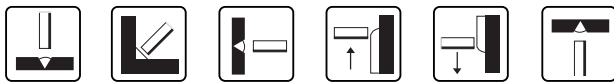
Sizes available and recommended currents (DC wire⊕)

Dia.	(mm)	1.2	1.6
Amp.	F	140~360	180~460
	H-Fil		
	V	140~260	180~260

Package

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

Welding positions



Approved by

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