

Flux Cored Welding Wire

K-71TB

For 490MPa high tensile steel (Basic type)

Classifications

| | | | |
|---------------------|-------------------------|-----------------------|-------------------------|
| EN ISO 17632-A:2015 | : T42 2 B C1 1 H5 | AWS A5.20-2005(R2015) | : E71T-5C/-5M |
| | : T46 2 B M21 1 H5 | AWS A5.36-2016 | : E71T5-C1/M21A2-CS1-H8 |
| EN ISO 17632-B:2015 | : T49 3 T5-1C1(M21)A H5 | KS D 7104-2012 | : YFW-C(A)502B |
| JIS Z 3313-2009 | : T49 2 T5-1 C/MA-U H5 | | |

Description

- It is designed for welding of 490MPa high tensile steel
- Served as both carbon dioxide and mixture gas.
- It has excellent CVN impact properties at sub-zero temperatures.
- Wire is a fully basic type of flux cored wire for all-position welding
- It provide good arc stability, low spatter generation

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂,
- Mix: Ar+20% CO₂ (15~25l/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

| Shielding gas | C | Si | Mn | P | S |
|-----------------|------|------|------|-------|-------|
| CO ₂ | 0.02 | 0.60 | 1.60 | 0.015 | 0.011 |

Typical mechanical properties of all-weld metal

| | Y.S (MPa) | T.S (MPa) | El. (%) | IV (J) | | Remarks |
|----------------|--------------|--------------|------------|--------|-------|-----------------|
| | | | | -20°C | -30°C | |
| AWS A5.20 | min. 390 | 490~670 | min. 22 | ≥ 27 | | |
| EN ISO 17632-B | min. 390 | 490~670 | min. 18 | ≥ 27 | | |
| Example | 550 | 610 | 30 | 65 | 55 | CO ₂ |

Notes on usage and welding condition

- Refer to page 219~221 for more information on usage
- When you use the 100% CO₂ gas, get a good weldability

Package

| Dia. (mm) | 1.2 | 1.4 | 1.6 |
|---------------|-----------------|-----|-----|
| Spool (kg) | 5, 12.5, 15, 20 | | |
| Pailpack (kg) | 100 ~ 300 | | |

Approvals

KS, JIS

- Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.