

## Flux Cored Welding Wire

# K-71T Plus

For 490MPa high tensile steel

### Classifications

EN ISO 17632-A:2015	: T42 2 P C1 1 H5	AWS A5.20-2005(R2015)	: E71T-9C
EN ISO 17632-B:2015	: T49 3 T1-1C1A H5	AWS A5.36-2016	: E71T1-C1A2-CS1-H4
JIS Z 3313-2009	: T49 3 T1-1CA H5	KS D 7104-2012	: YFW-C502R

### Description

- It is designed for welding of 490MPa high tensile steel with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a titania type of flux cored wire for all-position welding
- It also provide excellent usability with stable arc, less spatter levels, smooth bead shape

### Welding positions



### Polarity & shielding gas

- CO<sub>2</sub>: 100%CO<sub>2</sub> (15~25ℓ/min)
- DCEP (DC+)

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

Shielding gas	C	Si	Mn	P	S
CO <sub>2</sub>	0.03	0.40	1.20	0.015	0.012

### Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20℃	-30℃	
AWS A5.20	min. 390	490~670	min. 22	≥ 27		
EN ISO 17632-B	min. 390	490~670	min. 18	≥ 27		
Example	560	600	28	80	60	CO <sub>2</sub>

### Notes on usage and welding condition

- Refer to page 219~221 for more information on usage.
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting

### Package

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