

# K-71TM

For 490MPa high tensile steel

## Classifications

EN ISO 17632-A:2015	: T42 0 R C1 1 H5	AWS A5.20-2005(R2015)	: E71T-1C/-1M
	: T46 0 R M21 1 H10	AWS A5.36-2016	: E71T1-C1/M21A2-CS1-H8
EN ISO 17632-B:2015	: T49 2 T1-1C1(M21)A-U H5(H10)	KS D 7104-2012	: YFW-A(C)502R
JIS Z 3313-2009	: T49 2 T1-1C/MA-U H10		

## 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
- The shielding gas should be used Ar+20~25%CO<sub>2</sub> for welding, low spatter generation, smooth bead shape, high X-ray safety

## Welding positions



## Polarity & shielding gas

- Mix: Ar+20% CO<sub>2</sub> (15~25ℓ/min)
- 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
Mix	0.03	0.59	1.44	0.013	0.010

## 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	≥ 47		
Example	550	610	30	65	50	Mix

## Notes on usage and welding condition

- Refer to page 219~221 for more information on usage
- When you use the mixture 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

ABS, BV, DNV\*GL, LR, RINA, TUV, JIS, KS

\* Please refer to our homepage([www.kiswel.com](http://www.kiswel.com)) for further detailed information regarding approvals.