

Flux Cored Wire High Tensile Strength Steel

KFX-71T

Classification

AWS	A5.20	E71T-1C
JIS	Z3313	T49J0T1-1CA-U
EN	7632-A	T 42 2 P 1
GB	T 10045	E501T-1

Shielding Gas: CO₂

Applications and Features

- (1) KFX-71T is suitable for welding 490N/mm² grade steel.
- (2) It provides: good mechanical properties, deep penetration, and excellent weldability, less fume, stable arc, good slag removal and excellent X-ray quality welds.
- (3) Ideal for multi-pass welding in ship-building, tanks, bridges, steel structures and constructions.

Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.050	0.51	1.26	0.010	0.008

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy V-Notch °C	J (kgf -m)
570 (58.1)	510(52.0)	29	-18	100(9.8)
			-29	85(8.7)

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6
F	120~300	150~400	180~450
H-fillet	120~300	150~350	180~400
V-up	120~200	150~320	180~240
H	120~280	150~320	180~350
V-down	200~260	220~270	230~280