

## Flux Cored Wire High Tensile Strength Steel

# KFX-71M

### Classification

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

Shielding Gas: 80%Ar+20%CO<sub>2</sub>

### Applications and Features

- (1) KFX-71M is designed for welding with Argon mixed gas.
- (2) It provides: stable arc, good slag removal, less fume emission and low spatters.
- (3) It is ideal for steel structures, bridges and industrial machines.

### Welding position

All Positions

### Welding Instruction

Please refer to Appendix D.

### Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.060	0.56	1.65	0.012	0.009

### Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %	Charpy V-Notch °C	J (kgf -m)
590(60.2)	520(53.1)	31	-18	115(11.7)
			-29	90(9.2)

### Size and Suggested Operating Range (DC+)

Diameter (mm)		1.2	1.4	1.6
Amp	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