

Flux Cored Wire for High Tensile Strength Steel

KFX-71M

Classification

AWS A 5.20/A5.20M	E71T-1C(M)/E491T-1C(M)
JIS Z3313	T49J0T1-1 C(M)A-U
EN ISO 17632-A	T42 2 P C1(M21) 1 H10
GB T10045	T49 2 T1-1 C1(M21) H10

Shielding Gas:100%CO₂/80%Ar+20%CO₂

Applications and Features

- (1) KFX-71M is suitable for welding 490N/mm² grade steel.
- (2) Good mechanical properties, crack resistance, less fume, stable arc, good slag removal, good bead appearance and excellent X-ray quality welds.
- (3) Ideal for welding ship-building, tank, construction machine, steel structure and bridge.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

Shielding Gas	C	Si	Mn	P	S
C1	0.04	0.714	1.33	0.0155	0.0107
M21	0.03	0.722	1.57	0.0136	0.0085

Typical Mechanical Properties of Weld Metal

Shielding Gas	Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
	N/mm ²	N/mm ²	%	°C	J
C1	612	585	28	-20	89
M21	650	594	26	-20	75

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6
F/HF	140~300A/23~36V	150~350A/22~34V	200~450A/28~42V
H	140~280A/22~33V	150~280A/22~32V	220~280A/23~29V
V-up/OH	140~220A/22~28V	150~230A/22~28V	160~280A/22~28V