

Flux Cored Wire for High Tensile Strength Steel

KFX-71T

Shielding Gas:100%CO₂

Classification

AWS A 5.20/A5.20M	E71T-1C/E491T-1C
JIS Z3313	T49J2T1-1 CA-U
EN ISO 17632-A	T42 2 P C1 1 H10
GB T10045	T 49 2 T1-1 C1 A

Applications and Features

- (1) KFX-71T 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%)

C	Si	Mn	P	S
0.05	0.46	1.45	0.018	0.007

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
556	483	30	-30	72

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
V-down	230~280A/28~33V	250~300A/28~32V	250~320A/28~32V