

## Flux Cored Wire for High Tensile Strength Steel

# KX-71T

### Classification

AWS A 5.20/A5.20M	E71T-1C/E491T-1C
JIS Z3313	T49J0T1-1CA-U
EN ISO 17632-A	T42 2 P C1 1 H10
GB T10045	T 49 2 T1-1 C1 A

Shielding Gas: 100%CO<sub>2</sub>

### Applications and Features

- (1) KX-71T is suitable for all-position welding of 490N/mm<sup>2</sup> 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 of shipbuilding, 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
0.04	0.45	1.31	0.015	0.006

### Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm <sup>2</sup>	N/mm <sup>2</sup>	%	°C	J
543	470	30	-20	106

### 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