

Flux Cored Wire for High Tensile Strength Steel

KFX-71M

Classification

AWS A 5.20	E71T-1C/T-9C H8
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JIS Z3313	T49J0T1-1 C/M A-U
EN ISO 17632-A	T42 3 P C1 1 H10
	T46 3 P M21 1 H10
CWB certified	E491T1-C1A3-CS1-H8
CSA W48/AWSA5.36M	E491T1-M21A3-CS1-H8

Shielding Gas: 100%CO₂/80%Ar+20%CO₂

Applications and Features

- (1) KFX-71M is suitable for welding 490N/mm² grade steel with CO₂ and mix gas.
- (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 shipbuilding, 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	0.05	0.46	1.40	0.014	0.016
M21	0.04	0.55	1.57	0.011	0.014

Typical Mechanical Properties of Weld Metal

Shielding Gas	Tensile Strength		Yield Strength		Elongation		Charpy V-Notch	
	N/mm ²	N/mm ²	%	°C	J	°C	J	
C1	567	502	26	-20	109	-30	86	
M21	611	548	26	-20	121	-30	100	

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
V-up/OH	140~220A/22~28V	150~230A/22~28V	160~280A/22~28V