

KF71 C

FLUX CORED WIRE FOR MILD AND HIGH TENSILE STEEL FLUX CORED WIRE

Classifications:

AWS A5.20 E71T-1C
A5.20M E491T-1C
EN T 42 2 P C 1 H5
ISO 17632 B-T492T1-1CA-K

Characteristics and Applications:

KF71 C is a rutile flux cored wire designed for all-positional welding on the wide applications spectrum of ship building, offshore platform, steel structures, boilers, machine structures, etc. Soft and stable arc, low fume and easy slag removal could be obtained.

Welding Position:

Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.12	1.75	0.90	0.20	0.50	0.30	0.03	0.03	0.08
KF71 C	0.045	1.28	0.53	0.01	0.05	0.03	0.022	0.018	0.02

Typical Mechanical Properties of Weld Metal:

Mechanical Property	Y.S. (MPa)	T.S. (MPa)	EI (%)	CVN(J/°C)
AWS	390	490-670	22	27J /-20°C
KF71 C	495	570	27	105J /-20°C

Notes on Usage:

1. DCEP.
2. Pure CO₂ gas (>99.98%) is recommended.
3. Increase 1-2 volt when welding cable length more than 15 meters.
4. Proper storage is recommended when open the packing.

Sizes Available and Recommended Parameters:

Diameter/mm	1.2	1.4	1.6
Volt	23-30	24-36	25-40
Amp	150-300	170-360	200-400
Stick-Out(mm)	15-25	15-25	20-30
Gas Flow(l/min)	20-25	20-25	20-25