



KF71 CJ

FLUX CORED WIRE FOR HIGH STRENGTH STEEL

Classifications:

AWS A5.20 E71T-9C-J
A5.20M E491T-1C-J
EN T 46 4 P C 1 H 5
JIN Z3313 YFL-A503R

Characteristics and Applications:

KF71 CJ is gas shielding flux cored wire for 490Mpa high strength steel, it can all position welding. The working temperature is -40°C, it has less spatter stable arc, slag is very easy to remove, excellent X-ray detection property and perfect low temperature impact ductility. It is applied in welding ocean platform, port machine, low temperature vessel, etc.

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
Tested	0.043	1.20	0.04	0.02	0.48	0.04	0.015	0.012	0.01

Typical Mechanical Properties of Weld Metal:

Mechanical Property	Y.S. (MPa)	T.S. (MPa)	EI (%)	CVN(J/°C)
AWS	390	490-670	22	27J /-4 0°C
Tested	495	570	28	106J /-4 0°C

Notes on Usage:

1. Electric choice : DC+.
2. Protecting gas: recommended over 99.98% purity of CO₂.
3. It should to turn up voltage 1-2V when uses electric cable length over 15m.
4. It's necessary to cover the flux cored wire by canvas if it needs on wire feeder for one night.

Sizes Available and Recommended Parameters:

Diameter/mm	1.2	1.4	1.6
Volt	23-30	24-36	25-40
Amp	130-250	170-360	200-400
Stick-Out(mm)	15-25	15-25	20-30
Gas Flow(l/min)	20-25	20-25	20-25

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CMI

50 Toegye-ro 18-gil, Jung-gu,
Seoul, South Korea.
www.ecoweldkorea.com