



# KF71 CJ SR

FLUX CORED WIRE FOR HIGH STRENGTH STEEL

## Classifications:

AWS A5.20 E71T-1C-J  
A5.20M E491T-1C-J  
EN ISO 17632-A:T42 4 PC11  
EN ISO 17632- B:T49 4T1-1 C 1A

## Application:

1. Suitable for welding in offshore platform, port machinery, shipbuilding, bridge structure, low temperature storage vessel and etc.

## Characteristics:

1. Soft and stable arc, few spatter, beautiful weld bead appearance, easy slag removal, few smoke and excellent weldability.

2. Excellent -40°C low temperature impact toughness, and stable CTOD value.

Welding Position:  Polarity: DC+

## Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.18	2.00	0.90	0.20	0.50	0.30	0.03	0.03	0.08
Tested	0.12	1.75	0.90	0.20	0.50	0.30	0.03	0.03	0.08
KF71 CJ SR	0.034	1.24	0.37	0.03	0.45	0.01	0.011	0.005	0.01

## Typical Mechanical Properties of Weld Metal:

Mechanical Property	Y.S. (MPa)	T.S. (MPa)	EI (%)	CVN(J/°C)
AWS	390	490-670	18	27J /- 40°C
Tested	390	490-670	22	27J /- 40°C
KF71 CJ SR	505	560	28	118J/-40°C

## Notes on Usage:

1. Shielding gas: CO<sub>2</sub>
2. Preheat and interpass temperature : 150±15°C.

## Sizes Available and Recommended Parameters:

Diameter/mm	1.2	1.4	1.6
Volt	25-32	24-36	25-40
Amp	150-300	170-360	200-400
Stick-Out(mm)	15-20	15-20	20-30
Gas Flow(l/min)	15-25	15-25	15-25

# eco weld

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