

**Characteristics and Applications:**

KSF-71B-O is a self-shielded flux cored wire for single or limited multi-pass all position welds on mild steels used for field construction, erection and fabrication of bridges and shipbuilding where secondary shielding gas is not practical. Stable arc, few spatter and smoke, good welding bead appearance and easy slag removal can be obtained.

**Welding Position:**

**Typical Chemical Composition of Weld Metal:**

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	Al
AWS	0.30	1.75	0.60	0.20	0.50	0.30	0.03	0.03	1.8
KSF-71B-O	0.25	0.09	0.40	0.01	0.01	0.01	0.009	0.002	1.70

**Typical Mechanical Properties of Weld Metal:**

Mechanical Property	YS(Mpa)	TS(Mpa)	EL%	CVN J/°C
AWS	-	490	-	-
Typical	490	600	20.5	-

**Recommended Welding Parameter:**

Dia./mm	0.8	0.9	1.0	1.2
Volt	20-26	20-28	20-30	22-32
Amp	120-160	130-200	140-230	140-250
Stick-out(mm)	15-20	15-20	15-20	15-20

**Notes on Usage:**

1. Self-shielded welding machines used for welding KSF-71B-O
2. Remove water, dust and oil from base .
3. Excellent mechanical property can be obtained by maintaining 150°C inter pass temperature during multi-pass welding.
4. It's necessary to cover the flux cored wire by canvas if it needs on wire feeder one night.