



# KSF-71-GS

Self-Shielded Flux Cored Wire

## Classifications:

AWS A5.20 E71T-GS  
A5.20M E491T-GS

## Characteristics and Applications:

KSF-71-GS is a self-shielded flux cored wire designed for single pass welding on thin galvanized or carbon steel, ranging from 3/16" to 20 gauge. KSF-71-GS requires no external gas-shielding and should be welded with DCEN (straight polarity). This gasless wire is popular for the home workshop welder because of its advantages on easy hand carry, less spatter, fast travel speed good penetration, and easy slag removal. KSF-71-GS can be used for welding galvanized sheet metal, repair of automobile sheet metal, welding ductwork and joining of galvanized roofing sheet metal,

Welding Position:

## Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	Al
AWS	--	--	--	--	--	--	--	--	--
Tested	0.20	0.75	0.50	0.02	0.01	0.01	0.010	0.002	1.65

## Typical Mechanical Properties of Weld Metal:

Mechanical Property	Y.S. (MPa)	T.S. (MPa)	EI (%)	CVN(J/°C)
AWS	--	490	--	--
Tested	423	615	24.0	--

## Notes on Usage:

1. Self-shielded welding machines used for welding KSF 71-GS.
2. Remove water, dust and oil from base metal.
3. It's necessary to cover the flux cored wire by canvas if it needs on wire feeder for one nigh.

## Sizes Available and Recommended Parameters:

Diameter/mm	0.8	0.9	1.0	1.2	1.6
Volt	18-24	18-28	20-30	20-30	20-30
Amp	100-160	100-200	120-230	140-250	160-260
Stick-Out(mm)	10-15	10	15	10	15

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