

Flux Cored Welding Wire

K-71TSR

For 490MPa low temperature service steel (PWHT)

Classifications

EN ISO 17632-A:2015	: T42 4 P C1 1 H5	AWS A5.20-2005(R2015)	: E71T-12CJ H4
EN ISO 17632-B:2015	: T49 4 T1-1C1 AP-N1-U H5	AWS A5.36-2016	: E71T1-C1A/P4-CS2-H4
JIS Z 3313-2009	: T49 4 T1-1C AP-N1-U H5	KS D 7104-2012	: YFL-C504R

Description

- It is designed for welding of 490MPa low temperature steels (NACE/API steel)
- Typical applications include railcar, automotive machinery, shipbuilding, bridges, heavy equipment etc
- Wire is a titania type of flux cored wire for all-position welding
- It feature excellent mechanical properties, easy slag removal, low spatter generation, and good impact value at low temperatures down to -40°C in the PWHT conditions

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Ni
CO ₂	0.02	0.45	1.41	0.010	0.009	0.41

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-30°C	-40°C	
AWS A5.20	min. 390	490-620	min. 22	≥27		
EN ISO 17632-B	min. 390	490-670	min. 18		≥ 47	
Example AS-weld	578	612	25	138	119	
(CO ₂) PWHT	558	600	27	69	52	620°Cx2Hr

Notes on usage and welding condition

- Refer to page 219~221 for more information on usage
- In order to prevent crack at low temperatures, preheat and maintain interpass temperature at 100~200°C

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		

Approvals

ABS, BV, DNV*GL, KR, LR, NK, RS, JIS

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.