Supercored 71

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C
JIS Z3313 T49 2 T1-1 C A H10
EN ISO 17632-A-T 42 2 P C 1

Applications

All position welding of machinery, shipbuilding, bridges. Impact values of weld metal are good.

Characteristics on Usage

Supercored 71 is a flux cored wire which has been designed to get a good usability in all position for wide range of welding currents. With its quiet and smooth arc, its slag detachability is very good.

Notes on Usage

① Proper preheating(50~150° C)(122~302° F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
② One-side welding defects such as hot cracking may occur with wrong welding parameter, such as high welding speed.
③ Use 100% CO_2 gas.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB) 3G (PF.PG) 4G (PE)	DC +	CO_2

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.03	0.51	1.26	0.010	0.011

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)
545 (79,100)	572 (83,100)	28	0 (32)	110 (81)
			-20 (-4)	70 (52)

Approval

KR, ABS, LR, BV, DNV, GL, NK, TÜV, DB, CE, RINA, MRS, CRS

I Packing(Including Ball Pac)

Dia. (mm)	1.0	1.2	1.4	1.6	Spool(kg)	12.5	15	20
(in)	.039	.045	.052	1/16	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	120~300	150~350	200~400
V-up,OH	120~260	140~270	180~280
V-down	200~300	220~320	250~300

FCAW