

SC-71SR

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C/-9C-JJ-12C-J H4
JIS Z3313 T49 4 T1-1 C AP H5
EN ISO 17632-A-T 42 4 P C 1 H5

Applications

Oil and gas construction, pipe and off-shore structures.

Characteristics on Usage

SC-71SR is a titania type flux cored wire for all position welding for use with CO₂ gas. It provides excellent notch toughness at low temperature, not only as-welded also stress relieved state.

Notes on Usage

① Use 100%CO₂ gas.

Welding Position



1G (PA) 2F (PB) 3G (PF) 4G (PE)

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.05	0.40	1.20	0.011	0.010	0.38

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J (ft · lbs) -30°C(-22°F) -40°C(-40°F)	
560 (81,300)	580 (84,200)	28	115 (85)	80 (59)
540 (78,400)	560 (81,300)	30	84 (62)	60 (44)

As welded
PWHT(620° C x 2hr)

Approval

ABS, BV, DNV, LR, GL
CW, CCS

I Packing

Dia. (mm) 1.2 1.4
(in) .045 .052

Spool(kg) 12.5 15 20
(lbs) 28 33 44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)
F & HF	120~300	150~350
V-up, OH	120~260	140~270
V-down	200~300	220~320

FCAW