

# SF-71MC

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C/-1M/-9C/-9M/-12C/-12M  
EN ISO 17632-A-T 46 3 P M 1  
EN ISO 17632-A-T 46 2 P C 1

## Applications

All position welding for ship hulls, vehicles, bridges, chemical plant machinery and other metal fabrication.

## Characteristics on Usage

SF-71MC is a titania type flux cored wire applicable for all-position welding by 100%CO<sub>2</sub> shielding gas or 75%Ar+25%CO<sub>2</sub> shielding gas.

Less spattering and good slag removability shorten the time of bead grinding operation.

## 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 Use 100% CO<sub>2</sub> gas or Ar-CO<sub>2</sub> Mixture.

## Welding Position



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

## Current

DC +

## Shielding Gas

CO<sub>2</sub>/Ar + 20~25%CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Shielding Gas
0.04	0.40	1.20	0.010	0.012	100%CO <sub>2</sub>
0.04	0.50	1.41	0.010	0.014	75%Ar + 25%CO <sub>2</sub>

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	CVN-Impact Value J (ft · lbs)		Shielding Gas
			-20°C (-4°F)	-30°C (-22°F)	
510 (74,000)	550 (79,900)	28	95 (70)	75 (55)	100%CO <sub>2</sub>
540 (78,400)	605 (87,700)	28	110 (81)	90 (66)	75%Ar + 25%CO <sub>2</sub>

## Approval

ABS, LR, BV, DNV,  
TÜV, DB, CE, CWB

## I Packing(Including Ball Pac)

Dia. (mm) 1.2 1.4 1.6  
(in) .045 .052 1/16

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)	1.6 (1/16)
F	120~300	150~350	180~400
HF	120~300	150~350	180~340
V-up & OH	120~260	150~270	180~280
V-Down	200~300	220~300	250~300