

Flux Cored Welding Wire

K-71UT

For 490MPa low temperature service steel

Classifications

EN ISO 17632-A:2015 : T42 4 P C1 1 H5	AWS A5.20-2005(R2015) : E71T-9CJ H4
EN ISO 17632-B:2015 : T49 4 T1-1C1 A-U H5	AWS A5.36-2016 : E71T1-C1A4-CS1-H4
JIS Z 3313-2009 : T49 4 T1-1 C A-U H5	KS D 7104-2012 : YFL-C504R

Description

- It is designed for welding of 490MPa low temperature steels
- 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

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	0.04	0.30	1.35	0.014	0.010	0.39

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	490~670	min. 22		≥ 27	
EN ISO 17632-B	min. 390	490~670	min. 18		≥ 47	
Example	540	600	27	76	55	CO ₂

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.