

# SPECIALTY METALS

## TITANIUM - STAINLESS - EXOTIC

### Need metal? We get it!

## SpecMet CSF 71T-1

For mild steel and 490N/mm<sup>2</sup> class  
high tensile strength steel

**AWS** A5.20 E71T-1C/1M - A5.36 E71T1-C1[M21]A0-CS1-H8  
**KS** D 7104 YFW-C50DR  
**JIS** Z 3313 T49J 0 T1-1 C A-U  
**EN** ISO 17632-A T42 0 P C[M] 1 H10 - ISO 17632-B T49 2 T1-1 C[M] A-H10  
**AS/NZS** ISO 17632-B:2006 T49J 0 T1-1 C A-U H10



### Applications

Butt, fillet welding of 490N/mm<sup>2</sup> class high strength steel and low temperature steel of structure such as ships, bridges, buildings and storage tanks etc

### Characteristics

- (1) CSF-71T is a titania type flux cored wire and designed for all-position welding by single pass & multi pass with CO<sub>2</sub> gas shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) It provides a good welding efficiency thank to high deposition rate particularly.

### Notes on Usage

- (1) The optimum flow of CO<sub>2</sub> for shielding is 20~25l/min.
- (2) The distance between tip & base metal is to be 15~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (4) Thick heavy plate should be welded under proper preheating & interpass temperature.

### Typical chemical composition of weld metal (%) (shielding gas: 100% CO<sub>2</sub>)

C	Mn	Si	P	S
0.04	1.25	0.58	0.013	0.010

### Typical mechanical properties of weld metal (%) (shielding gas: 100% CO<sub>2</sub>)

YP N/mm <sup>2</sup> (MPa)	TS N/mm <sup>2</sup> (MPa)	EL (%)	IV (J)	
			0°C	-20°C
517	574	29.0	109	74

### Size and recommended current range (DC+)

Dia. Mm(in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Flat H-Fillet	Amp	180~340	200~360	200~400
V-Up	Amp	120~220	140~260	160~260
V-Down	Amp	120~240	140~260	160~280
O.H	Amp	120~220	140~260	160~260

Approvals: CO<sub>2</sub> : ABS, BV, DNV, GL, KR, LR, NK, RINA, CWB

MIX : ABS, BV, DNV, GL, LR, RINA

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