SPECIALTY METALS

SpecMet CSF 71T-1

For mild steel and 490N/mm2 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/NZSISO 17632-B:2006 T49J 0 T1-1 C A-U H10

Applications

Butt, fillet welding of 490N/mm2 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 CO2 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 CO2 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_2)

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_2)

YP N/mm2(MPa)	TS N/mm2(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: CO2 : ABS, BV, DNV, GL, KR, LR, NK, RINA, CWB MIX : ABS, BV, DNV, GL, LR, RINA

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