

CSF-71SR

For 490N/mm² class high strength steel
and low temperature steel

AWS	A5.20	E71T-12C-J
KS	D 7104	YFL-C503R
JIS	Z3313	T494T1-1CP-N1-H10

Applications

For 490N/mm² class high strength steel and low temperature steel 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-71SR 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 excellent impact value at low temperatures down to -40°C in the as-welded and PWHT conditions.

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%CO₂)

C	Mn	Si	P	S	Ni
0.04	1.40	0.45	0.015	0.012	0.40

Typical mechanical properties of weld metal

(Shielding gas : 100%CO₂)

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IV (J)		Heat Treatment
			-20°C	-40°C	
520	590	28	156	132	As Weld
500	560	30	135	110	620°C×8hr

Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400
	V-up	120~220	140~260	160~260
	V-down	120~240	140~260	160~280
	OH	120~220	140~260	160~260