

CSF-71S

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

AWS A5.20 E71T-9C-J
KS D 7104 YFL-C504R
JIS Z3313 T494T1-1CA-N1-H5

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-71S 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.
- (4) Weld metal has good impact properties at -40°C.

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
0.05	1.30	0.40	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)	
			-20°C	-40°C
513	595	29.0	140	110

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

• Approval : ABS, BV, DNV, GL, KR, LR, NK