

# SFC-71

AWS A5.20 E71T-1C/1M  
JIS Z3313 T 49J 2 T1-1 C/M A-U  
EN ISO 17632-A T42 2 P C/M 1 H5

## FLUX CORED WIRES FOR 490N/mm<sup>2</sup> HIGH TENSILE STEEL

### DESCRIPTION :

SFC-71 is an all-positional rutile flux cored wire designed to be used with CO<sub>2</sub> or Ar/CO<sub>2</sub> gas mixture. It can be used on all-position welds with both single and multiple pass welds for mild steel and low alloy steels.

### APPLICATIONS :

It is widely used for shipbuilding, storage vessels, structural fabrication, machinery and piping, etc.

### NOTE ON USAGE :

1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

### WELDING POSITION:



### TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) : (Shielding Gas: 100% CO<sub>2</sub>)

Weld Metal Analysis :

Carbon (C)	0.051
Manganese (Mn)	1.36
Silicon (Si)	0.48
Phosphorus (P)	0.012
Sulphur (S)	0.009

### TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO<sub>2</sub>)

YP N/mm <sup>2</sup>	474
TS N/mm <sup>2</sup>	573
EL%	28

### TYPICAL IMPACT VALUES :

IV -20°C J	92
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### APPROVALS :

ABS, BV, CCS, CE, CR, DNV · GL, LR, NK, KR, JIS

### SUGGESTED WELDING PARAMETERS (DC <->)

Parameters	Diameter (mm)		1.2mm		1.4mm		1.6mm	
	Flat	Vertical-up	Flat	Vertical-up	Flat	Vertical-up		
Welding Position								
Voltage (Volt)	28 ~ 36	25 ~ 26	28 ~ 38	25 ~ 28	30 ~ 40	26 ~ 30		
Current (Amp)	150 ~ 300	150 ~ 220	180 ~ 350	150 ~ 230	200 ~ 400	160 ~ 250		
Stickout (mm)	10 ~ 15		15 ~ 20		15 ~ 30			
Flow Rate (l / min)	15 ~ 25		15 ~ 25		15 ~ 25			