

SF-71LF

AWS A5.20 / ASME SFA5.20 E71T-1C

TYPE : Rutile

Applications

All position welding in shipbuilding, machinery, bridges, buildings, vehicles using mild and higher strength steels.

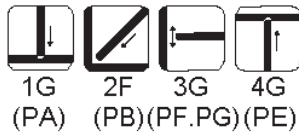
Characteristics on Usage

SF-71LF is a very widely used rutile type flux cored wire for all position welding with CO₂ shielding gas. As the deposition rate is higher than solid wire and manual arc electrodes, highly efficient welding can be performed. Arc stability is excellent. Spatter loss is low and slag covering is uniform and easily removed. Fume generation is lower than conventional flux cored wires.

Notes on Usage

- 1) Proper preheat and interpass temp. (50-150°C) must be used in order to release hydrogen which may cause cracking in welds when the wire is used for medium and heavy plates.
- 2) Use 100% CO₂ gas.

Welding Position



Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.03	0.50	1.45	0.009	0.011

Typical Mechanical Properties of All-Weld Metal

YS MPa	TS MPa	EL (%)	Temp.	CVN-Impact Value J
550	590	27	0	90

Approval I Packing(Including Ball Pac)

ABS, NK, LR, DNV

Dia. (mm) 1.2 1.6

Spool(kg) 15

Sizes Available and Recommended Currents (Amp.)

Size, mm	1.2	1.6
F & HF	120~300	200~400
V-up,OH	120~260	180~280
V-down	200~300	250~300

Diam.	15 kg Spool
1.2mm	HKSF71LF12
1.6mm	HKSF71LF16

TALARC Pty Ltd
10-16 Syme St
Brunswick, Vic 3056
Ph. +61 3 9388 0588 Fax: +61 3 9388 0710
W: www.talarc.com E: sales@talarc.com