

# SC-71LHM Cored

AWS A5.20 / ASME JFA A5.20 E71T-1M/-9M  
EN ISO 17632-A-T 46 3 P M 1 H5

TYPE : Rutile

## Applications

All position welding of building, shipbuilding, bridge construction machinery and vehicles.

## Characteristics on Usage

SC-71LHM Cored is a rutile type flux cored wire for all position welding. It has extra low hydrogen level (H5) and provides an exceptionally smooth and stable arc with a fast freezing slag system.

## 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 Ar + 20~25% CO<sub>2</sub> gas.

## Welding Position



1G 2F 3G 4G  
(PA) (PB)(PF.PG)(PE)

## Current

DC +

## Shielding Gas

Ar+20~25% CO<sub>2</sub>

## Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.05	0.50	1.20	0.012	0.015

## Typical Mechanical Properties of All-Weld Metal

YS MPa	TS MPa	EL (%)	Temp. °C	CVN-Impact Value J
580	600	28	-30	80

## Approval

ABS, LR, BV, DNV, GL,  
TÜV, DB, CE, CWB

## I Packing

Dia. (mm)

1.2 1.6

Spool(kg)

15

## Sizes Available and Recommended Currents (Amp.)

Size, mm	1.2	1.6
F & HF	220 ~ 290	260 ~ 330
V-up, OH	180 ~ 250	230 ~ 290
V-down	210 ~ 290	270 ~ 330

Diam.	15 kg Spool
1.2mm	HKSC71LHM12
1.6mm	HKSC71LHM16

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