

SF-71MC

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C/-1M/-9C/-9M/-12C/-12M
EN ISO 17632-A-T 46 3 P M 1
EN ISO 17632-A-T 46 2 P C 1

Applications

All position welding for ship hulls, vehicles, bridges, chemical plant machinery and other steel fabrication.

Characteristics on Usage

SF-71MC is a rutile type flux cored wire applicable for all-position welding by 100% CO₂ shielding gas or 75%Ar+25%CO₂ shielding gas. Less spatter and easy slag removal shorten the clean-up time.

Notes on Usage

- 1) Proper preheat (50~150°C) and interpass temp 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 or Ar-CO₂ Mixture.

Welding Position



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

Current

DC+

Shielding Gas

CO₂ or Ar + 20~25% CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Shielding Gas
0.04	0.40	1.20	0.010	0.012	100% CO ₂
0.04	0.50	1.41	0.010	0.014	75%Ar + 25% CO ₂

Typical Mechanical Properties of All-Weld Metal

YS MPa	TS MPa	EL (%)	CVN-Impact Value J -20°C -30°C		Shielding Gas
510	550	28	95	75	100% CO ₂
540	605	28	110	90	75%Ar + 25% CO ₂

Approval

ABS, LR, BV, DNV,
TÜV, DB, CE, CWB

I Packing(Including Ball Pac)

Dia. (mm) 1.2 1.6 Spool(kg) 15

Sizes Available and Recommended Current (Amp.)

Size, mm	1.2	1.6
F	120~300	180~400
HF	120~300	180~340
V-up & OH	120~260	180~280
V-Down	200~300	250~300

Diam.	15 kg Spool
1.2mm	HK71MC12
1.6mm	HK71MC16

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