

Supercored 71

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C
JIS Z3313 T49 2 T1-1 C A H10
EN ISO 17632-A-T 42 2 P C 1

Applications

All position welding of machinery, shipbuilding, bridges. Impact values of weld metal are good.

Characteristics on Usage

Supercored 71 is a flux cored wire which has been designed to get a good usability in all position for wide range of welding currents. With its quiet and smooth arc, its slag detachability is very good.

Notes on Usage

- ① Proper preheating(50~150° C)(122~302° F) and interpass temperature must be used in order to release hydrogen which may cause cracking in weld metal when electrodes are used for medium and heavy plates.
- ② One-side welding defects such as hot cracking may occur with wrong welding parameter, such as high welding speed.
- ③ Use 100% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.03	0.51	1.26	0.010	0.011

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
545 (79,100)	572 (83,100)	28	0 (32) -20 (-4)	110 (81) 70 (52)

Approval

KR, ABS, LR, BV, DNV, GL,
NK, TÜV, DB, CE, RINA, MRS,
CRS

I Packing(Including Ball Pac)

Dia. (mm)	1.0	1.2	1.4	1.6	Spool(kg)	12.5	15	20
(in)	.039	.045	.052	1/16	(lbs)	28	33	44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	120~300	150~350	200~400
V-up,OH	120~260	140~270	180~280
V-down	200~300	220~320	250~300

Diam.	15 kg Spool	200kg Drum
1.2mm	HKSCORD7112 HVSCORD7112	
1.6mm	HKSCORD7116 HVSCORD7116	HVSCORD7116200

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