

SF-71LF

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C
JIS Z3313 T49J 0 T1-1 C A-U H10

Applications

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

Characteristics on Usage

SF-71LF is the most widely used titania type flux cored wire for all position welding with CO₂ shielding gas. As deposition rate is higher than solid wire and manual metal arc electrode, highly efficient welding can be performed.

Arc stability is excellent. Spatter loss is low and slag covering is uniform with good removability.

Fume generation is lower than conventional flux cored wires.

SF-71LF is effective for use in insufficient ventilation areas.

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	0.50	1.45	0.009	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)
550 (79,900)	590 (85,700)	27	0 (32)	90 (66)

Approval

ABS, NK, LR, DNV

I Packing(Including Ball Pac)

Dia. (mm) 1.2 1.4 1.6
(in) .045 .052 1/16

Spool(kg) 15 20
(lbs) 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	180~280	180~280
V-down	200~300	220~320	250~300