SC-71LH

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C/-9C
JIS Z3313 T49 3 T1-1 C A-U H5
EN ISO 17632-A-T 42 2 P C 1 H5

Applications

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

Characteristics on Usage

SC-71LH is titania type flux cored wire for all position welding. It has extra low hydrogen levels(H5) and provide an exceptionally smooth and stable arc with a fast freezing slag system.

Notes on Usage

① Proper Preheating(50~150℃)(122~302℉) 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% CO_2 gas.

Welding Position	Current	Shielding Gas
 1G (PA) 2F (PB) 3G (PF.PG) 4G (PE)	DC +	CO_2

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.06	0.47	1.35	0.014	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. ℃ (℉)	CVN-Impact Value J (ft · lbs)
550 (79,800)	590 (85,600)	27	-30 (-22)	70 (52)

Approval

ABS, BV, DNV, NK, LR, GL, KR, RINA

I Packing(Including Ball Pac)

Dia. (mm)	1.2	1.4	1.6	Spool(kg)	12.5	15	20
(in)	.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	220~290	240~320	260~330
V-up,OH	180~250	200~260	230~290
V-down	210~290	250~320	270~330