

SC-71LHM Cored

TYPE : Rutile

AWS A5.20 / ASME JFA A5.20 E71T-1M/9M
JIS Z3313 T49 3 T1-1 M A-U H5
EN ISO 17632-A-T 46 3 P M 1 H5

Applications

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

Characteristics on Usage

SC-71LHM Cored is a titania 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 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 Ar + 20~25% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

Ar+20~25%CO₂

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(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
580 (84,200)	600 (87,100)	28	-30 (-22)	80 (59)

Approval

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

I Packing(Including Ball Pac)

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

Spool(kg) 12.5 15 20
(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