# SC-71MJ

*TYPE : Rutile*

**AWS A5.20 / ASME SFA5.20 E71T-9M-J**
**JIS Z3313 T49 4 T1-1 M A-U H5**
**EN ISO 17632-A T46 4 P M 1 H5**

## Applications

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

## Characteristics on Usage

① SC-71MJ is a titania type flux cored wire for all position welding.
② It provides excellent notch toughness at low temperature.
③ It provides 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 electoredes 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%$CO_2$ gas.

| Welding Position | Current | Shielding Gas |
|---|---|---|
|  1G (PA) 2F (PB) 3G (PF.PG) 4G (PE) | DC + | Ar + 20~25%$CO_2$ |

## Typical Chemical Composition of All-Weld Metal (%)

| C | Si | Mn | P | S | Ni |
|---|---|---|---|---|---|
| 0.06 | 0.30 | 1.10 | 0.012 | 0.011 | 0.42 |

## Typical Mechanical Properties of All-Weld Metal

| YS MPa(lbs/in²) | TS MPa(lbs/in²) | EL (%) | CVN-Impact Value J (ft · lbs) -30℃ (-22℉) | -40℃ (-40℉) |
|---|---|---|---|---|
| 545 (79,100) | 583 (84,500) | 25.0 | 126 (93) | 80 (59) |

## Approval

ABS, BV, DNV

## I Packing(Including Ball Pac)

| | | | | | | |
|---|---|---|---|---|---|---|
| Dia. (mm) | 1.2 | 1.4 | 1.6 | Spool(kg) | 12.5 | 15 |
| (in) | .045 | .052 | 1/16 | (lbs) | 28 | 33 |

## Sizes Available and Recommended Currents (Amp.)

| Size mm (in) | 1.2 | 1.4 | 1.6 |
|---|---|---|---|
| F & HF | 120 ~ 300 | 160 ~ 350 | 180 ~ 380 |
| V-up, OH | 120 ~ 260 | 140 ~ 270 | 160 ~ 320 |
| V-down | 140 ~ 300 | 160 ~ 320 | 180 ~ 360 |