

SC-71MSR

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-12M-J
EN ISO 17632-A-T 46 4 P M 1 H5

Applications

Oil and gas construction, pipe, and off-shore structures.

Characteristics on Usage

SC-71MSR is a titania type flux cored wire for all position welding. It provides excellent notch toughness at low temperature, not only as-welded but also stress relieved state.

All position welding can be achieved with excellent flat bead appearance, less spatter and easy slag removal and high welding current in vertical up position can be performed.

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 crack in weld metal when electrodes are used for medium and heavy thick 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 for welding.

Welding Position



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

Current

DC +

Shielding Gas

Ar+20~25%CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S	Ni
0.06	0.35	1.24	0.012	0.012	0.45

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	CVN-Impact Value J (ft · lbs)		As welded PWHT(620° C × 2hr)
			-40°C(-40°F)	-51°C(-60°F)	
542 (78,600)	577 (83,600)	30	115 (85)	85 (63)	
523 (75,700)	552 (80,000)	33	90 (66)	70 (52)	

Approval

ABS, BV, DNV, LR, GL
TÜV, DB, CE, CWB

I Packing

Dia. (mm) 1.2
(in) .045

Spool(kg) 12.5 15 20
(lbs) 28 33 44

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)
F & HF	200~290
V-up, OH	180~250
V-down	210~280