

Applications

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

Characteristics on Usage

- ① SL-71LH is a titania type Seamless flux cored wire for all position welding.
- ② It has extra low hydrogen levels(H5).
- ③ It provides an exceptionally smooth and stable arc with a fast freezing slag system.

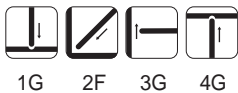
Notes on Usage

- 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 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 100%CO₂ gas.

Welding Position(All-Position)

Current

Shielding Gas



Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.04	0.60	1.40	0.012	0.012

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in²)	TS MPa(lbs/in²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
540 (78,300)	585 (84,900)	28	-30 (-22)	60 (44)

Approval

I Packing(Including Ball Pac)

Dia. (mm) (in)	1.2	1.4	1.6	Spool(kg) (lbs)	12.5	15
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Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2	1.4	1.6
F	220~290	240~320	260~330
V-up,OH	180~250	200~260	230~290
V-down	210~290	250~320	270~330