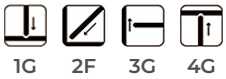
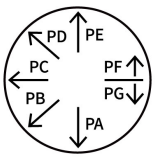
SC-71HJ

Classification

AWS AWS A5.20 / ASME SFA-5.20 E71T-1C,-9C-J
JIS Z 3313 T 49 4 T1-1 C A
EN ISO 17632-A T42 4 P C1 1

Welding Positions





Features

- Designed for welding with 100%CO2 shielding gas
- Smooth and stable arc with a fast freezing slag

Polarity

DC +

Application Areas

- Shipbuilding
- General fabrication
- Structural fabrication

Shielding Gas

100%CO_2

Approvals

ABS	BV	DNV	KR	LR	NK	RS
✓	✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Ni
100%CO_2	0.04	0.51	1.61	0.010	0.010	0.40

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100%CO_2	585 (85)	635 (92)	27	-40 (-40)	85 (63)

Diameter / Welding Parameters / Packaging

Wire Diameter mm(in)	Current (A)	Packaging
1.2 (0.045)	110~280	Spool 5kg (11lbs), 12.5kg (28lbs), 15kg (33lbs), 20kg (44lbs) Drum 100kg (221lbs), 200kg (441lbs), 250kg (551lbs)
1.4 (0.052)	110~280	
1.6 (1/16)	120~300	