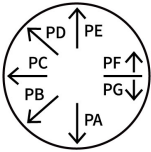


SC-71SR

Classification

AWS AWS A5.20 / ASME SFA-5.20 E71T-1C/-9C-J/-12C-J
H4
JIS Z 3313 T49 4 T1-1 C AP
EN ISO 17632-A T42 4 P C11 H5
KS 7104 YFL-C503R

Welding Positions



Features

- Designed for welding with 100%CO2 shielding gas
- Good impact value at low temperature (As Welded and PHWT)

Polarity

DC +

Application Areas

- Shipbuilding
- Offshore structure
- Pipe & Pipeline
- Pressure vessel

Shielding Gas

100% CO2

Approvals

ABS	BV	CCS	DNV	KR	LR	NK	CWB
✓	✓	✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S	Ni
100% CO2	0.05	0.40	1.20	0.010	0.010	0.38

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Condition	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
100% CO2	As Welded	560 (81)	580 (84)	28	-40 (-40) -50 (-60)	80 (59) 65 (48)
100% CO2	PWHT 620°C×2hr	540 (78)	560 (81)	30	-40 (-40) -50 (-60)	60 (44) 45 (33)

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	

SMW

GMW

GTW

FCW

Metal-cored Wire

SAW Wire

SAW Flux