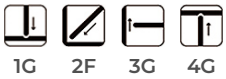
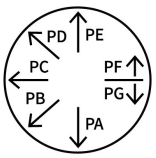
SF-71MC

Classification

AWS AWS A5.20 / ASME SFA-5.20
E71T-1C,-1M,-9C,-9M,-12C,-12M
EN ISO 17632-A T46 2 P C1 1 H10, T46 3 P M21 1 H10

Welding Positions





Features

- Designed for welding with 100%CO2 and Ar+20~25%CO2 shielding gas
- Smooth arc and low spatter, good weldability
- Good bead appearance

Polarity

DC +

Application Areas

- Shipbuilding
- General fabrication
- Structural fabrication

Shielding Gas

100% CO2
Ar+20~25% CO2

Approvals

ABS	BV	DNV	LR	CWB	CE	DB	TUV
✓	✓	✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S
100% CO2	0.05	0.40	1.15	0.010	0.010
Ar+20~25% CO2	0.05	0.51	1.32	0.010	0.010

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% CO2	518 (75)	575 (83)	28	-30 (-20)	63 (46)
Ar+20~25% CO2	575 (83)	610 (88)	25	-30 (-20)	86 (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)
1.6 (1/16)	120~300	