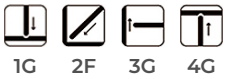
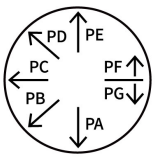
SF-71R

Classification

AWS AWS A5.20 / ASME SFA-5.20 E71T-1C H4
EN ISO 17632-A T42 2 P C1 1 H5

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	CE
✓	✓

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

Shielding Gas	C	Si	Mn	P	S
100% CO2	0.05	0.50	1.38	0.010	0.010

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	520 (75)	585 (84)	28	-20 (0)	90 (66)
100% CO2	PWHT 620°C×2hr	473 (69)	553 (80)	30	-20 (0)	60 (44)

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	