

# SF-71

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C  
JIS Z3313 T49J 0 T1-1 C A-U H10  
EN ISO 17632-A-T 42 0 P C 1

## Applications

All position welding of building, shipbuilding, bridges, machinery and vehicles.

## Characteristics on Usage

SF-71 is a titania type flux cored wire for all position welding with CO<sub>2</sub>. Compared with solid wire, spatter loss is low, bead appearance is beautiful and arc is soft with good stability. Slag covering is uniform with good removal.

## 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 electrodes 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% CO<sub>2</sub> gas

## Welding Position



1G 2F 3G 4G  
(PA) (PB)(PF.PG)(PE)

## Current

DC +

## Shielding Gas

CO<sub>2</sub>

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

C	Si	Mn	P	S
0.04	0.49	1.29	0.010	0.009

## Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in <sup>2</sup> )	TS MPa(lbs/in <sup>2</sup> )	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
548 (79,600)	582 (84,500)	28	0 (32)	86 (64)

## Approval

KR, ABS, LR, BV, DNV, GL,  
NK, TÜV, CWB, CE, CCS,  
CCRS, RINA

## I Packing(Including Ball Pac)

Dia. (mm)	1.0	1.2	1.4	1.6	Spool(kg)	5	12.5	15	20
	(in)	.039	.045	.052		1/16	(lbs)	11	28

## Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	120~300	200~350	200~400
V-up, OH	120~260	180~280	180~280
V-down	200~300	220~320	250~300