

Supercored 71H

TYPE : Rutile

AWS A5.20 / ASME SFA5.20 E71T-1C/-9C/-9C-J
JIS Z3313 T49 4 T1-1 C A H5
EN ISO 17632-A-T 42 4 P C 1 H5

Applications

All position welding of shipbuilding, bridges, building and structural fabrication.

Characteristics on Usage

Supercored 71H is a titania flux cored wire for all position welding with high amperage. Its impact value is very good under high heat-input, arc is smooth and slag detachability is excellent .

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% CO₂ gas.

Welding Position



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

Current

DC +

Shielding Gas

CO₂

Typical Chemical Composition of All-Weld Metal (%)

C	Si	Mn	P	S
0.03	0.46	1.36	0.008	0.011

Typical Mechanical Properties of All-Weld Metal

YS MPa(lbs/in ²)	TS MPa(lbs/in ²)	EL (%)	Temp. °C (°F)	CVN-Impact Value J (ft · lbs)
550 (79,900)	570 (82,800)	27	-30 (-22) -40 (-40)	90 (66) 60 (44)

Approval

I Packing(Including Ball Pac)

KR, ABS, LR, BV, DNV, GL,	Dia. (mm)	1.2	1.4	Spool(kg)	15	20
NK, TÜV, CWB, CE, DB, CCS,	(in)	.045	.052	(lbs)	33	44
RINA, MRS						

Sizes Available and Recommended Currents (Amp.)

Size mm (in)	1.2 (.045)	1.4 (.052)	1.6 (1/16)
F & HF	120~300	150~350	180~400
V-up,OH	120~260	140~270	160~280
V-down	200~300	220~320	250~300

FCAW