

# CSF-71T

For mild steel and 490N/mm<sup>2</sup> class high tensile strength steel

AWS	A5.36	E71T1-C1[M21]A0-CS1-H8
AWS	A5.20	E71T-1C, -1M
KS	D 7104	YFW-C50DR
JIS	Z 3313	T49J0T1-1CA-U

## Applications

Butt, fillet welding of mild steel & 490N/mm<sup>2</sup> high tensile strength steels of structure such as ships, bridges, buildings and storage tanks etc.

## Characteristics

- (1) CSF-71T is a titania type flux cored wire and designed for all-position welding by single pass & multi pass with CO<sub>2</sub> gas shielding.
- (2) It provides the excellent usability with stable arc, less spattering, good bead appearance, better slag removal, and less quantity of welding fume comparable to solid wire.
- (3) It provides a good welding efficiency thank to high deposition rate particularly.

## Notes on usage

- (1) The optimum flow of CO<sub>2</sub> for shielding is 20~25 ℓ /min.
- (2) The distance between tip & base metal is to be 15~25mm.
- (3) Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec and more.
- (4) Thick heavy plate should be welded under proper preheating & interpass temperature.

## Typical chemical composition of weld metal (%)

(Shielding Gas : 100%CO<sub>2</sub>)

C	Mn	Si	P	S
0.04	1.25	0.58	0.013	0.010

## Typical mechanical properties of weld metal

(Shielding Gas : 100%CO<sub>2</sub>)

YP N/mm <sup>2</sup> (MPa)	TS N/mm <sup>2</sup> (MPa)	EL %	IV (J)	
			0℃	-20℃
517	574	29	109	74

## Size & recommended current range (DC +)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp.	F & H-F	180~340	200~360	200~400
	V-up	120~220	140~260	160~260
	V-down	120~240	140~260	160~280
	OH	120~220	140~260	160~260

- Approval : CO<sub>2</sub> : ABS, BV, DNV GL, KR, LR, NK, RINA, CWB  
MIX : ABS, BV, DNV GL, LR, RINA