

K-71TSS

For 490MPa corrosion resisting steel against sulfuric acid

Classifications

JIS Z 3313 : T49J 0 T1-1CA-U H5 AWS A5.36 : E71T1-C1A0-CS1 H8

Description

- It is designed for the mild and medium tensile steels that are used for flue gas desulfurization facilities
- The weld metal contains Ni, Cu alloys and has good anticorrosion against sulfuric acid and hydrochloric acid
- Wire is a titania type of flux cored wire for all-position welding
- It features excellent mechanical properties, easy slag removal, low spatter generation, high X-ray safety

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Ni	Cu
CO ₂	0.05	0.45	0.85	0.012	0.010	0.20	0.33

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 0°C	Remarks
EN IOS 17632-B	min. 390	490~670	min. 22	≥ 47	
JIS Z 3313	min. 400	490~670	min. 18	≥ 47	
Example	483	597	29	75	CO ₂

Notes on usage and welding condition

- Refer to page 211~213 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input

Package

Dia. (mm)	1.2	1.4	1.6
Spool (kg)	5, 12.5, 15, 20		
Pailpack (kg)	100 ~ 300		