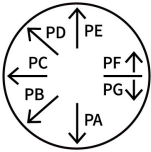


SF-71

Classification

AWS AWS A5.20 / ASME SFA-5.20 E71T-1C
JIS Z 3313 T49J 0 T1-1 C A-U
EN ISO 17632-A T42 0 P C1 1
KS D7104 YFW-C50DR

Welding Positions



Features

- Designed for welding with 100%CO2 shielding gas
- Good performance and low spatter
- Smooth and stable arc with a fast freezing slag

Polarity

DC +

Application Areas

- Shipbuilding
- General fabrication
- Structural fabrication

Shielding Gas

100%CO₂

Approvals

ABS	BV	CCS	CR	DNV	KR	LR	NK	RINA	RS	CWB	CE	TUV
✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S
100%CO ₂	0.04	0.49	1.29	0.013	0.011

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft · lbs)
100%CO ₂	548 (79)	582 (84)	28	0 (32) -20 (0)	75 (55) 40 (30)

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	
1.6 (1/16)	120-300	