



KISWEL

KISWEL K-71T

Classifications:

EN ISO 17632-A: T42 0 P C 1 H10
EN ISO 17632-B: T49 0 T1-1CA-U H10
AWS A5.20: E71T-1C

KS D 7104: YFW-C50DR
JIS Z 3313: T49J 0 T1-1CA-U H10

Typical Chemistry Composition of Weld Deposit:

| C | Si | Mn | P | S |
|-------|-------|-------|-------|-------|
| <0.12 | <0.90 | <1.75 | <0.03 | <0.03 |

Description:

- It is designed for welding of 490MPa high tensile steel with outstanding mechanical properties.
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications.
- Wire is a titania type of flux cored wire for all-position welding.
- Weld Deposit has easy slag removal, low spatter and smooth bead shape

Typical Mechanical Properties:

| Yield Strength (Mpa) | Tensile Strength (Mpa) | Elongation (%) | Impact Value (J) |
|-------------------------|---------------------------|-------------------|---------------------|
| min. 400 | 480 - 650 | min. 22 | 70 (0°C) |

Welding Parameters:

| Wire Diameter | Shielding Gas | Current (A) | | Voltage (V) | |
|---------------|-----------------|-------------|------|-------------|------|
| | | Min. | Max. | Min. | Max. |
| 1.20 mm | CO ₂ | 130 | 280 | 22 | 30 |



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