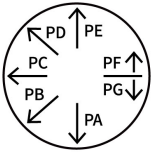
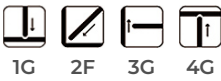


SC-71LHM Cored

Classification

AWS AWS A5.20 / ASME SFA-5.20 E71T-1M,-9M
JIS Z 3313 T49 3 T1-1 M A-U
EN ISO 17632-A T46 3 P M21 1 H5

Welding Positions



Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Smooth and stable arc with a fast freezing slag
- Low hydrogen level(H5)

Polarity

DC +

Application Areas

- Shipbuilding
- General fabrication
- Structural fabrication

Shielding Gas

Ar+20~25% CO2

Approvals

ABS	BV	DNV	LR	CWB	CE	DB	TUV
✓	✓	✓	✓	✓	✓	✓	✓

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

Shielding Gas	C	Si	Mn	P	S
Ar+20~25% CO2	0.05	0.5	1.20	0.011	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)
Ar+20~25% CO2	580 (84)	600 (87)	28	-30 (-20)	75 (55)

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	

SMW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux