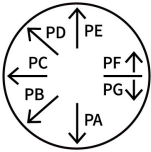


SC-71MSR

Classification

AWS AWS A5.20 / ASME SFA-5.20 E71T-12M-J
EN ISO 17632-A T46 4 P M21 1 H5

Welding Positions



Features

- Designed for welding with Ar+20~25%CO2 shielding gas
- Good impact value at low temperature (As Welded and PHWT)

Polarity

DC +

Application Areas

- Shipbuilding
- Offshore structure
- Pipe & Pipeline
- Pressure vessel

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	Ni
Ar+20~25% CO2	0.06	0.35	1.24	0.010	0.010	0.45

Typical Mechanical Properties of All-Weld Metal

Shielding Gas	Condition	Yield Strength MPa(ksi)	Tensile Strength MPa(ksi)	Elongation (%)	Temperature °C (°F)	Impact Toughness J (ft·lbs)
Ar+20~25% CO2	As Welded	542 (79)	577 (84)	30	-40 (-40)	81 (60)
					-50 (-60)	64 (47)
Ar+20~25% CO2	PWHT 620°C×2hr	523 (76)	552 (80)	33	-40 (-40)	57 (42)
					-50 (-60)	49 (36)

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	

SWAW

GMAW

GTAW

FCAW

Metal-cored Wire

SAW Wire

SAW Flux