

Tubular Wires

AWS E71T-1C/1M, 9C/9M

K-71T Plus

AWS E71T-1C/1M, 12C/12M

K-71TP

Mild Steel

Typical Applications

Formulated for welding of 70,000 psi tensile steel for use with both CO₂ or Ar/CO₂ gas properties. Typical applications include machinery, shipbuilding, offshore structures, bridges and general fabrication.

This wire is designed for low temp. impact properties. It can be used in a variety of applications including shipbuilding, pressure vessels, bridges and the construction industries. Ar+20-25%CO₂ gases should be used.

Characteristics Of Usage

1. This is a titania type flux cored wire for all position welding.
2. It provides excellent feedability and soft welding arc, as well as less spatter generation.
3. Provides low fume generation and has good toughness at low temperatures.

1. Titania type for all-position welding.
2. For 70,000 psi tensile strength steels.
3. Provides improved impact toughness and lower Mn content required in ASME Boiler and Pressure Vessel Code, Section IX.
4. It has easy slag removal, good weld soundness, and low spatter.

Weld Metal Composition

SG	CO ₂
Carbon	0.03 %
Silicon	0.40 %
Manganese	1.20 %
Phosphorus	0.015 %
Sulphur	0.012 %

SG	CO ₂
Carbon	0.025 %
Silicon	0.43 %
Manganese	1.12 %
Phosphorus	0.011 %
Sulphur	0.011 %

Mechanical Properties

Y-P (psi)	77,000
T-S (psi)	83,000
EI	28 %
V-notch	74 ft/lb @ -22 °F

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T-S (psi)	83,000
EI	28 %
V-notch	74 ft/lb @ -22 °F

Available Sizes / Rec. Parameters

Dia in (mm)	F	Amp	
		H	V
.035 (.9)	100-240	120-220	120-160
.045 (1.2)	120-300	140-260	160-240
1/16 (1.6)	180-400	200-360	180-260

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Packaging

[Detailed Packaging Information](#)

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Welding Positions

All Positions

All Positions

Approved



KISWEL
WELDING PRODUCTS

Supplier... For The Highest Demands

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