

**AWS A5.20 E71T-1C/1M**

**EN758 T42 2 P C/M 1 H5**

**SOREX SFC-71**

**DESCRIPTION :**

SFC-71 is an all-position rutile flux cored wire designed to be used with CO<sub>2</sub> or Ar / CO<sub>2</sub> gas mixture. It can be used on all-position welds with both single and multiple pass welds on mild steel and low alloy steels.

**APPLICATIONS :**

It is widely used for shipbuilding, storage vessels, structural fabrication, machinery and piping, etc.

**NOTE ON USAGE :**

1. Use DC (+) polarity.
2. Maintain a higher welding speed in order to get enough penetration in the down hand welding position.

**TYPICAL CHEMICAL COMPOSITION OF WELD METAL (wt%) :**

Weld Metal Analysis : (Shielding Gas: 100% CO<sub>2</sub>)

Carbon (C)	0.042
Manganese (Mn)	1.36
Silicon (Si)	0.48
Phosphorus (P)	0.012
Sulphur (S)	0.010

**TYPICAL MECHANICAL PROPERTIES OF WELD METAL: (Shielding Gas: 100% CO<sub>2</sub>)**

YP N/mm <sup>2</sup>	474
TS N/mm <sup>2</sup>	573
EL%	28

**TYPICAL IMPACT VALUES :**

IV -20°C J	92
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**APPROVALS AND CONFORMANCES :**

**SUGGESTED WELDING PARAMETERS**

Parameters	Diameter (mm)			
	0 1.2mm		0 1.6mm	
Welding Position	Flat	Vertical-up	Flat	Vertical-up
Voltage (Volt)	30 ~ 34	25 ~ 26	33 ~ 40	26 ~ 28
Current (Amp)	250 ~ 300	150 ~ 220	300 ~ 400	160 ~ 220
Stickout (mm)	10 ~ 15	10 ~ 15	15 ~ 30	15 ~ 30
Flow Rate (l / min)	15 ~ 25	15 ~ 25	15 ~ 25	15 ~ 25

**SOREX WELDING CO.,LTD.**

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The Professional Quality

MILD STEEL AND HIGH TENSILE STEEL FLUX CORED WIRES