HYUNDAI WELDING

Rev. 06

Supercored 71

FLUX CORED ARC WELDING CONSUMABLE
FOR WELDING OF MILD & 490MPa CLASS
HIGH TENSILE STEEL

2022.02

HYUNDAI WELDING CO., LTD.

Supercored 71

❖ Specification

AWS A5.20	E71T-1C
(AWS A5.20M	E491T-1C)
EN ISO 17632-A	T42 2 P C1 1
JIS Z3313	T49 2 T1-1 C A

AWS D1.8

Wire Dia. mm(in)		
1.2(0.045)	1.4(0.052)	1.6(1/16)

* AWS D1.8 is available upon request

❖ Applications

All position welding of machinery, shipbuilding, bridges. Impact values of weld metal are good.

❖ Characteristics on Usage

Supercored 71 is a flux cored wire which has been designed to get a good usability in all position for wide range of welding currents. With its quiet and smooth arc, its slag detachability is very good.

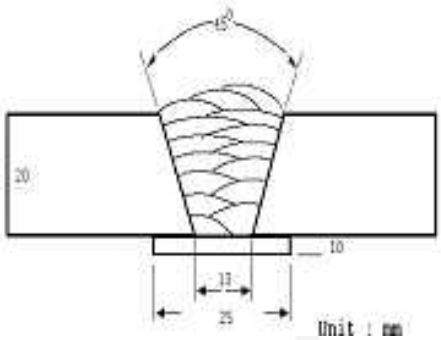
❖ Note on Usage

1. For preheating guidelines, please refer to your local standards and codes relative to your best practices
2. One-side welding defects such as hot cracking may occur with wrong welding parameter such as high welding speed.
3. Use 100% CO_2 gas.

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



[Joint Preparation & Layer Details]

Welding Position	:	1G(PA)
Diameter	:	1.2mm (0.045in)
Shielding Gas	:	100%CO_2
Flow Rate	:	20 ℓ /min
Amp./ Volt.	:	280A / 32V
Stick-Out	:	20~25mm (0.79~0.98in)
Pre-Heat	:	R.T .
Interpass Temp.	:	150±15℃ (302±59°F)
Polarity	:	DC(+)

❖ Mechanical Properties of all weld metal

Consumable	Tensile Test			CVN Impact Test J(ft · lbs)	
	YS MPa (lbs/in²)	TS MPa (lbs/in²)	EL (%)	-1℃ (30°F)	-18℃ (0°F)
Supercored 71	545 (79,000)	572 (83,000)	28	110 (81)	70 (52)
AWS A5.20 E71T-1C	≥ 390 (56,000)	490~670 (70,000~ 97,000)	≥ 22	≥27J at -18℃ (≥20ft · lbs at 0°F)	

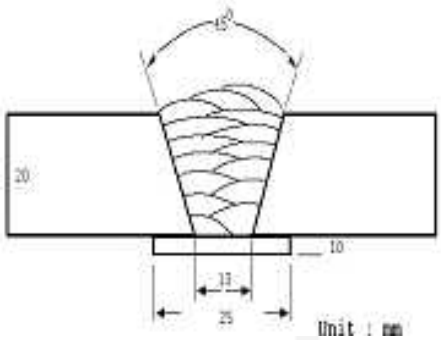
❖ Chemical Analysis of all weld metal(wt%)

Consumable	C	Si	Mn	P	S
Supercored 71	0.036	0.51	1.26	0.010	0.011
AWS A5.20 E71T-1C	≤ 0.12	≤ 0.9	≤ 1.75	≤ 0.03	≤ 0.03

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



[Joint Preparation & Layer Details]

Welding Position	:	1G(PA)
Diameter	:	1.4mm (0.052in)
Shielding Gas	:	100%CO_2
Flow Rate	:	20 ℓ /min
Amp./ Volt.	:	300A / 32V
Stick-Out	:	20~25mm (0.79~0.98in)
Pre-Heat	:	R.T .
Interpass Temp.	:	150±15℃ (302±59°F)
Polarity	:	DC(+)

❖ Mechanical Properties of all weld metal

Consumable	Tensile Test			CVN Impact Test J(ft · lbs)	
	YS MPa (lbs/in²)	TS MPa (lbs/in²)	EL (%)	-1℃ (30°F)	-18℃ (0°F)
Supercored 71	548 (79,000)	576 (84,000)	28	128 (94)	81 (60)
AWS A5.20 E71T-1C	≥ 390 (56,000)	490~670 (70,000~ 97,000)	≥ 22	≥27J at -18℃ (≥20ft · lbs at 0°F)	

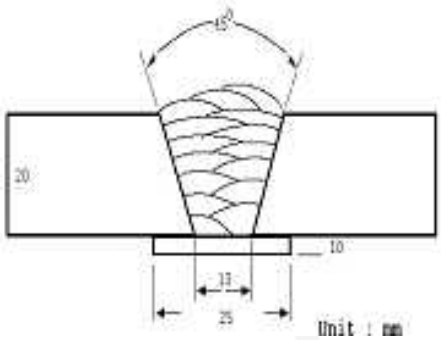
❖ Chemical Analysis of all weld metal(wt%)

Consumable	C	Si	Mn	P	S
Supercored 71	0.038	0.50	1.28	0.010	0.011
AWS A5.20 E71T-1C	≤ 0.12	≤ 0.9	≤ 1.75	≤ 0.03	≤ 0.03

Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



[Joint Preparation & Layer Details]

Welding Position	:	1G(PA)
Diameter	:	1.6mm (1/16in)
Shielding Gas	:	100%CO_2
Flow Rate	:	20 ℓ /min
Amp./ Volt.	:	320~330A / 29~30V
Stick-Out	:	20~25mm (0.79~0.98in)
Pre-Heat	:	R.T .
Interpass Temp.	:	150±15℃ (302±59°F)
Polarity	:	DC(+)

❖ Mechanical Properties of all weld metal

Consumable	Tensile Test			CVN Impact Test J(ft · lbs)	
	YS MPa (lbs/in²)	TS MPa (lbs/in²)	EL (%)	-1℃ (30°F)	-18℃ (0°F)
Supercored 71	551 (80,000)	586 (85,000)	27.5	105 (77)	66 (49)
AWS A5.20 E71T-1C	≥ 390 (56,000)	490~670 (70,000~ 97,000)	≥ 22	≥27J at -18℃ (≥20ft · lbs at 0°F)	

❖ Chemical Analysis of all weld metal(wt%)

Consumable	C	Si	Mn	P	S
Supercored 71	0.033	0.49	1.30	0.011	0.010
AWS A5.20 E71T-1C	≤ 0.12	≤ 0.9	≤ 1.75	≤ 0.03	≤ 0.03

Welding Efficiency

❖ Deposition Rate & Efficiency

Consumable (size)	Welding Conditions		Wire Feed Speed m/min (in/min)	Deposition Efficiency %	Deposition Rate kg/hr(lb/hr)
	Amp.(A)	Volt.(V)			
Supercored 71 1.2mm (0.045in)	200	26	10.2 (400)	84~87	3.4 (7.5)
	250	28	11.5 (450)	85~88	4.5 (9.9)
	300	33	15.3 (600)	86~88	5.2 (11.4)
Supercored 71 1.4mm (0.052in)	250	28	7.6 (300)	85~87	3.9 (8.6)
	300	32	10.2 (400)	85~88	4.8 (10.6)
	330	36	12.8 (500)	86~89	5.8 (12.8)
Supercored 71 1.6mm (1/16in)	280	31	6.4 (250)	85~88	4.2 (9.2)
	330	33	7.6 (300)	86~88	4.8 (10.6)
	350	34	8.1 (320)	87~89	5.3 (11.7)
	400	38	9.2 (360)	87~90	5.7 (12.5)
Remark				Deposition efficiency =(Deposited metal weight/ Wire weight used)×100	Deposition rate =(Deposited metal weight/ Welding time,min.)×60

* Shielding Gas : 100%CO_2

Diffusible Hydrogen Content

❖ Welding Conditions

Diameter	:	1.2mm (0.045in)	**Amps(A) / Volts(V)**	:	230A / 26V
Shielding Gas	:	100%CO_2	**Stick-Out**	:	20~25mm (0.79~0.98in)
Flow Rate	:	20 ℓ /min			
Welding Position	:	1G (PA)	**Welding Speed**	:	30 cm/min (12 in/min)
			Current Type & Polarity	:	DC(+)

❖ Hydrogen Analysis Using Gas Chromatography Method

Hydrogen Evolution Time	:	72 hrs
Evolution Temp.	:	45 ℃ (113°F)
Barometric Pressure	:	780 mm-Hg

❖ Result(㎖/100g Weld Metal)

X1	X2	X3	X4
5.3	**5.4**	**5.4**	**5.4**

Average Hydrogen Content 5.4 ㎖ / *100g Weld Metal*

Proper Welding Condition

❖ Proper Current Range

Consumable	Shielding Gas	Welding Position	Wire Dia,		
			1.2mm (0.045in)	1.4mm (0.052in)	1.6mm (1/16in)
Supercored 71	100%CO_2	F & HF	120~300Amp	150~350Amp	150~360Amp
		V-Up & OH	120~260Amp	140~270Amp	160~280mp
		V-Down	200~300Amp	220~320Amp	250~300Amp

Approvals

❖ Shipping Approvals

Welding Position	Register of shipping & Size					
	KR	ABS	LR	BV	DNV	NK
All V-Down	3SMG, 3YSMG ©H10 0.9~1.6mm (0.035~1/16in)	3SAH10, 3YSA 0.9~1.6mm (0.035~1/16in)	3S, 3YSH10 0.9~1.6mm (0.035~1/16in)	SA3M,3YMHH A3M,3YMHH 0.9~1.6mm (0.035~1/16in)	IIIYMSH10 0.9~1.6mm (0.035~1/16in)	KSW53G©H10 KAW53MG©H10 0.9~1.6mm (0.035~1/16in)

❖ F No & A No

F No	A No
6	1