

# SC-71MSR

Type : Rutile

SC-71MSR



## Conformances

AWS A5.20/ ASME SFA5.20 E71T-12M-J  
 EN ISO 17632-A T46 4 P M 1 H5  
 ABS 4Y400SA H5  
 LR 4Y40S H5  
 BV SA4Y40M HHH  
 DNV IVY40MSH5

GL 4Y40H5S  
 TÜV EN ISO 17632-A - T46 4 P M 1 H5  
 DB DIN EN ISO 17632-A-T 46 4 P M 2 H5  
 CE  
 CWB CSA W48 E491T-12MJ-H8

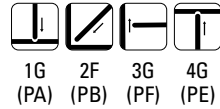
## Applications

- Pipe line
- Offshore structure
- Pressure vessel

## Features

- Good impact value at low temperature (As Welded and PHWT)

## Welding Position



## Current

DC +

## Shielding Gas

Ar + 20~25% CO<sub>2</sub>

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

C	Si	Mn	P	S	Ni
0.06	0.35	1.24	0.012	0.012	0.45

## Typical Mechanical Properties of All-Weld Metal

YS Mpa(lbs/in <sup>2</sup> )	TS Mpa(lbs/in <sup>2</sup> )	EL (%)	Temp °C(°F)	CVN-Impact Value J (ft.-lbs)	
542 (78,600)	577 (83,600)	30.0	-40 (-40) -51 (-60)	115 (85) 85 (63)	As Welded
523 (75,700)	552 (80,000)	33.0	-40 (-40) -51 (-60)	90 (66) 70 (52)	PWHT (620 @2hr)

## Typical Operating Procedures

Diameter, Polarity Shielding Gas	CTWD mm (in)	Wire Feed Speed m/min (in/min)	Voltage (volts)	Approx. Current (amps)	Deposition Rate kg/hr (lb/hr)	Efficiency (%)	
1.2mm (0.045 in) DC+							
80% Ar + 20% CO <sub>2</sub>	25 (1)	All Position					86~88
		4.4 (175)	20~25	110~140	1.6 (3.5)		
		5.7 (225)	21~26	120~150	2.0 (4.5)		
		7.0 (275)	22~27	130~160	2.5 (5.5)		
		8.3 (325)	22~27	160~190	2.9 (6.5)		
		8.9 (350)	23~28	170~200	3.2 (7.0)		
		10.2 (400)	24~29	200~230	3.6 (8.0)		
		Flat & Horizontal					
		11.4 (450)	25~31	210~240	4.1 (9.1)		
		12.1 (475)	26~32	230~260	4.3 (9.5)		
13.3 (525)	27~33	250~280	4.7 (10.4)				

## Diameter / Packaging

Diameter mm (in)	Spool			Pac		
	12.5kg (28lbs)	15kg (33lbs)	20kg (44lbs)	100kg (221lbs)	200kg (441lbs)	250kg (551lbs)
1.2 (0.045)	✓	✓	✓			