

ROFIL-71 SPL

ALL POSITION SEMI BASIC TYPE FLUX CORED WIRE FOR WELDING 490N/MM² HIGH TENSILE STEELS

BASIC ALLOY: FE, MN, SI
 AWS/SFA-5.20: E71T-5C/5M
 EN ISO 17632 B T493T1-ICA-K

KEY FEATURES:

Rofil-71 spl is a semi-basic mild steel flux cored wire designed for all position welding. its designed to be used with CO₂ gas for 490N/mm² grade high tensile steel. Its low temperature impact toughness is better than AWS A5.20 E71T-1C

APPLICATIONS

- Structural and pressure vessel grades.
- Welding of low and medium carbon steels grades
- Machinery and shipbuilding.
- Steels of SA-516 and equivalent grade steels, etc.

SHEILDING GAS

- Welding with CO₂ gas and Ar+ CO₂ gas mixture.

CHEMICAL COMPOSITION:

C	Mn	Si	S	P
0.065	1.25	0.42	0.030 Max	0.030 Max

MECHANICAL PROPERTIES

YS (N/mm ²)	UTS (N/mm ²)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT
390 Min.	490 min.	22 min.	Minus 30C : 40-70 J

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Gas Flow Rate L/min	Spool packing 12.5 kg.	Spool packing 15kg	Drum packing 100/200kg
1.20	3/ 64"	120-300	24-34	15-25	✓	✓	✓
1.40	1/ 18"	160-340	26-34	15-25	✓	✓	✓
1.60	1/ 16"	180-360	28-36	15-30	✓	✓	✓