



Quality Management System
in accordance with
ISO 9001
Cert # 05-R0925

CSF-71T Carbon Steel Flux-Cored Wire

CHOSUN WELDING CO., LTD.

U.S. ALLOY CO.
dba Washington Alloy
7010-G Reames Rd.
Charlotte, NC 28216
www.weldingwire.com



ALLOY DESCRIPTION AND APPLICATION:

CSF 71T is a baked flux cored wire designed for single or multi pass welding having a smooth arc transfer, low spatter, flat to slightly convex bead contour, with a high deposition rate and easily removal slag. This all-position baked wire has excellent feeding and low fume generation using 100% CO₂ or mixed gas making it a good choice for mild steel and higher strengths steels.

TYPICAL FCAW WELDING PROCEDURES; DCEP OPTIMUM IN BOLD (FLAT)

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	CO ₂ (cfh)
0.035	275- 580 -780	130- 200 -260	23-27-30	3/8-3/4"	35-40
0.045	200- 450 -600	150- 250 -335	22- 29 -33	1/2-1"	35-45
0.052	150- 400 -600	140- 275 -390	19- 28 -35	1/2-1"	40-50
1/16"	150- 330 -490	150- 330 -475	23- 30 -38	1/2-1"	40-50
5/64"	120- 250 -300	250- 385 -450	26- 29 -32	3/4-1 1/4"	40-50
3/32"	110- 185 -275	300- 425 -550	25- 29 -34	3/4-1 1/4"	40-50

Procedures may vary with change in position, base metals, filler metals, equipment and other changes. Use 1-2 volts less with mixed gas

TYPICAL WELD METAL CHEMISTRY (%) AND WELD METAL PROPERTIES;

	AWS Spec	CSF-71T	BASED ON 100% CO ₂ / MIX 75/25 IN BOLD		
			AWS Spec	CSF-71T	
Carbon	0.12 max	0.06/ 0.06	Tensile Strength (psi)	70-95,000	85,443 / 91,494
Manganese	1.75 max	1.34/ 1.41	Yield Strength (psi)	58,000 min.	73,176 / 83,256
Silicon	0.90 max	0.58/ 0.64	Elongation in 2"	22 % min.	30.5% / 28.8 %
Phosphorus	0.030 max.	0.014/ 0.015	Charpy V-notch at 0°F	20 ft·lbs min.	35.3 / 57.3 ft·lbs
Sulfur	0.030 max.	0.006/ 0.005	Chromium	0.20 max.	0.04/ 0.04
Copper	0.35 max.	0.02/ 0.02	Vanadium	0.08 max.	0.01/ 0.01
Nickel	0.50 max.	0.01/ 0.01			
Molybdenum	0.30 max.	0.01/ 0.01			

Hydrogen test on Lot # of F71TA0009G182 with 100 CO₂ was @ 3.6(ml/100gl) and 75% Ar + 25% CO₂ was @ 3.61

AVAILABLE SIZES: CSF-71T = Spools of .045, .052, 1/16" On 15#, 33# 44#

SPECIFICATIONS; AWS A5.20

ASME SFA 5.20

AWS A5.36

ASME SFA 5.36

(Formerly classified as E71T-1) H4 MAY ALSO BE REQUEST PRE HEAT

E71T-1C/1M

E71T-1C/1M

E71T1-C1[M21]A0-CS1-H8

E71T1-C1[M21]A0-CS1-H8



APPROVALS: ABS, BV, DNV GL, KR, NK, LR, BKI, CWB

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