



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

**CSF-71SRM**  
**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](http://www.weldingwire.com)



**ALLOY DESCRIPTION AND APPLICATION:**

CSF 71SRM 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 mixed gas making it a good choice for mild steel and higher strengths steels where excellent impact toughness values at low temperatures are required.

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

Wire Diameter	Wire Speed (ipm)	Amps	Volts	Electrical Stickout	(cfh)
0.035	275-580-780	130-200-260	23-26-30	3/8-3/4"	35-40
0.045	200- <b>450</b> -600	150- <b>250</b> -335	22- <b>28</b> -34	1/2-1"	35-45
0.052	150- <b>400</b> -600	140- <b>275</b> -390	20- <b>27</b> -35	1/2-1"	40-50
1/16"	150- <b>330</b> -490	150- <b>330</b> -475	23- <b>29</b> -38	1/2-1"	40-50
5/64"	120-250-300	250-385-450	26-28-32	3/4-1 1/4"	40-50
3/32"	110-185-275	300-425-550	25-28-34	3/4-1 1/4"	40-50

Procedures may vary with change in position, base metals, filler metals, equipment and other changes.

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

AWS Spec	CSF-71SRM	BASED ON 75/25 IN BOLD	AWS Spec	CSF-71SRM
Carbon	0.12 max	<b>0.03</b>	Tensile Strength (psi)	70-95,000
Manganese	1.75 max	<b>1.25</b>	Yield Strength (psi)	58,000 min.
Silicon	0.90 max	<b>0.33</b>	Elongation in 2"	22 % min.
Phosphorus	0.030 max.	<b>0.010</b>	Charpy V-notch at -40°F	20 ft·lbs min.
Sulfur	0.030 max.	<b>0.010</b>	Charpy V-notch at -60°F	62 ft·lbs
	Charpy V-notch at -50°F	<b>68 ft·lbs</b>	Hydrogen test on test 1809-1 with 75% Ar + 25% CO <sub>2</sub> was @ 3.97	

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

**SPECIFICATIONS;** AWS A5.20 E71T-12MJ  
 ASME SFA 5.20 E71T-12MJ  
 AWS A5.36 E71T12-M21P4-CS2-H8  
 ASME SFA 5.36 E71T12-M21P4-CS2-H8  
 (Formerly classified as E71T-12J) H4 MAY ALSO BE REQUEST



**APPROVALS:** ABS, DNV GL, CWB

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