

ROFIL-71T8-K6

LOW-ALLOY STEEL SELF-SHIELDED FLUX-CORED
WELDING WIRE

BASIC ALLOY: FE, MN, SI, NI
AWS/SFA-5.29: E71T8-K6 JH8
EN ISO 17632-A T42 4 1N1 Y
N 1 H10

KEY FEATURES:

ROFIL-71T8-K6 is a kind of low-alloy steel self-shielded flux-cored welding wire, which needs no shielding gas. The weld has excellent low temperature toughness. It has high deposition efficiency. The arc has strong penetration power with spurting appearance. High deposition rate

APPLICATIONS

- structure welding in open air
- pipe laying
- offshore oil rig
- bridges

SHEILDING GAS

- No Gas Required

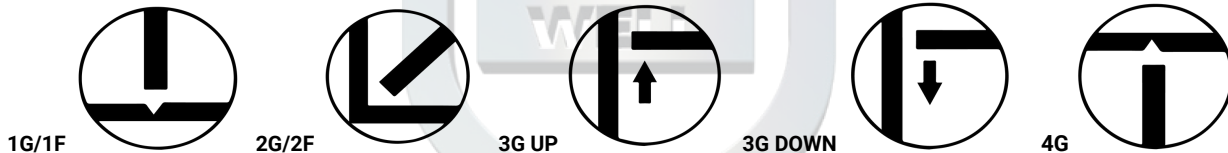
CHEMICAL COMPOSITION:

C	Mn	Si	S&P	Ni	Al	Cr	Mo
0.15 Max.	0.50-1.50	0.80 max.	0.030 Max	0.40-1.00	1.80 max	0.20 max.	0.15 max.

MECHANICAL PROPERTIES

YS (N/mm2)	UTS (N/mm2)	EL % (l=5d)	CHARPY "V" NOTCH IMPACT AT	Diffusible Hydrogen ml/100g
400 Min.	490-620	20 Min.	- 40C : 27 J min.	8.00 ml max.

WELDING POSITION



DIEMENSION, CURRENT CONDITION & PACKING DATA

Size (mm)	Size (inch)	Current Condition (DC+)	Voltage (V)	Spool packing 12.5 kg.	Spool packing 15kg
1.20	3/ 64"	120-300	18-22	✓	✓
1.40	1/ 18"	160-340	18-22	✓	✓
1.60	1/ 16"	180-360	18-22	✓	✓
2.00	5/64"	200-380	18-22	✓	✓