

# CHOSUN CSF-71LF

**AWS A5.20 CLASS E71T-1C/1M, 9C/9M H8**

CSF-71LF is a special formulation flux cored wire for single or multi-pass all position welds on mild steels and 490N/mm<sup>2</sup> (71,000 psi) class high strength steels. CSF-71LF is noted for its low spatter, smooth arc and ease of slag removal. CSF-71LF has been designed to provide excellent feed ability when used for all position welds of light, medium and heavy thickness plates using 75-80% Arbon + balance CO<sub>2</sub> mixed shield gas.

**KEY FEATURES:**

- All position welding property, less spatter, stable arc, thin slag
- Yields great penetration on light, medium or heavy gauge plate
- Able to run with either mixed gas or 100% CO<sub>2</sub> el
- Weld deposit exhibits great tie-in with self-peeling slag



** CHOSUN WELDING**

**ORDERING INFORMATION:**

- Part#: CSF-71LF --
- Diameter (Inch) available: .045, .052, 1/16
- Packaging available: 15 lb, 33 lb, 44 lb Spool, 550 lb drum

**TYPICAL WELD METAL CHEMISTRY (%)**

	C	Mn	Si	P	S	Ni	Va
CO <sub>2</sub>	0.04	1.35	0.45	0.011	0.009	0.01	0.01
Mixed	0.04	1.45	0.50	0.012	0.011	0.01	0.01

**TYPICAL WELD METAL MECHANICAL PROPERTIES**

	TENSILE STRENGTH	YEILD STRENGTH	ELONGATION	Impact value ft/lbs (-20°F)
CO <sub>2</sub>	76,852 psi	69,645 psi	32.8%	65
Mixed	88,455 psi	79,382 psi	30.5%	85