

BW-71U

Flux Cored Welding Wire

For 490N/mm² class high strength steel & low temperature steel.


betaweld[®]
creating better welding solutions

Specification: AWS A5.20:E71T-9C
AWS A5.36:E71T1-C1A2-CS1

Applications & Features:

BW-71U is used for butt & fillet welding of 490N/mm² class high strength steel & low temperature steels such as ships, bridges, buildings and storage tanks etc.

Characteristics:

BW-71U is a titania type flux cored wire designed for all positional Welding by single pass & multi pass with CO₂ gas shielding. Provides excellent usability with stable arc, less spattering, good bead appearance, better slag removal & low fume emissions compared with solid wire. Good welding efficiency due to high deposition rate. Weld metal has good impact properties at -30°C.

Notes on Usage:

The optimum flow for shielding is 20-25Lpm
The distance between tip & base metal is to be 20-25mm
Protect the weld with a screen to prevent blowholes caused by wind where the wind velocity is 2m/sec or more.
Thick heavy plate should be welded under proper preheating & interpass temperature.

Approvals:

ABS, BV, DNV, GL, KR, LR, NK

Part Numbers:

P/N: 2060 (1.2mm 15kg spool)
P/N: 2061 (1.6mm 15kg spool)



Typical chemical composition of weld metal (%)

C	Mn	Si	P	S	Ni
0.04	1.35	0.48	0.015	0.010	0.40

Typical mechanical properties of weld metal

YP N/mm ² (MPa)	TS N/mm ² (MPa)	EL %	IVJ (kgf-m)		Heat Treatment
			-20°C	-30°C	
504	584	28.0	130	95	AW
405	564	30.0	105	68	620°C×1hr

Size & recommended current range (DC+)

Dia. mm (in)		1.2 (0.045)	1.4 (0.052)	1.6 (0.062)
Amp	FLAT, H-FILLET	180~340	200~360	200~400
	V-UP	120~220	140~260	160~260
	V-DOWN	120~240	140~260	160~280
	O.H	120~220	140~260	160~260