

# GFL-71

Flux-cored wire for high tensile steel

490MPa Grade

## Classifications:

GB/T10045 T 49 2 T1-1 C1 A  
AWS A5.20 E71T-1C  
A5.20M E491T-1C  
EN ISO 17632-A:T42 2 P C1 1  
EN ISO 17632-B:T49 2 T1-1 C1 A  
JIS Z3313 T492T1-1CA-U

Approval: ABS, BV, CCS, DNV/GL, LR, NK, KR, RINA, CWB, RS, CE, VD.TUV

## Application:

1. Suitable for welding in shipbuilding, bridge structure, building structure, offshore platform, pipe, steel structure and etc.

## Characteristics:

1. Soft and stable arc, few spatter, beautiful weld bead appearance, easy slag removal, few smoke, and excellent weldability;
2. Excellent low temperature impact toughness.

Polarity: DC+

Welding Position:



## Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
GB/T	0.18	2.00	0.90	0.20	0.50	0.30	0.03	0.03	0.08
AWS	0.12	1.75	0.90	0.20	0.50	0.30	0.03	0.03	0.08
GFL-71	0.040	1.30	0.40	0.02	0.01	0.01	0.011	0.005	0.01

## Typical Mechanical Properties of Weld Metal:

Mechanical properties	Y.S.(MPa)	T.S.(MPa)	EI(%)	CVN(J/°C)	PWHT(°C × h)
GB/T	390	490-670	18	27/-20	AW
AWS	390	490-670	22	27/-20	AW
GFL-71	480	550	28	125/-20	AW

## Sizes Available and Recommended Parameters:

Dia/mm	1.2	1.4	1.6
Volt	23-32	24-36	25-40
Amp	150-300	170-360	200-400
Stick-Out ( mm )	15-20	15-20	18-25
Gas Flow ( l/min )	15-25	15-25	15-25

## Notes on usage:

1. Shielding gas: CO<sub>2</sub>;
2. Preheat and interpass temperature: 150 ± 15°C.

**KUNSHAN GINTUNE WELDING Co., LTD.**