

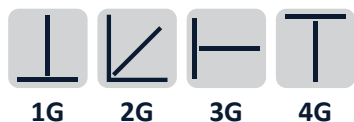
Applications

NEXXARC CF-71 is designed for all position single and multipass welding of low and medium carbon steels. suitable for joining steels conforming to ASTM SA-36 / SA-36M and A, B, C, D grades of SA-283 / SA-283 and SA-414 / SA-414M (P. No. 1) e.g. Fabrication in chemical plant machinery structures and Steel frames in Ship Building, Heavy Bridges and Towers.

Characteristic on Usage

NEXXARC CF-71 is an all position Rutile flux cored wire designed for optimum performance when using CO² shielding. The smooth metal transfer facilitates easy deposition of vertical-up stringer beads. The slag coverage is complete and designed for easy removal. Weld metal is consistently free of inclusions and porosity for X-ray soundness. The wire is formulated to produce fewer fumes, minimal spatter.

Welding Positions



Recommended Stick Out

15 - 20 mm

Shielding Gas

Carbon Dioxide (CO²) Shielding

Chemical Composition of Weld Metal

Element	C%	Mn%	Si%	S%	P%
Typical Values	0.05	1.25	0.38	0.010	0.018
Spec. Required	0.12 max	1.75 max	0.90 max	0.03 max	0.03 max

Mechanical Properties of Weld Metal

Property	U.T.S.	Y.S.	Elongation	CVN Impact
	(N/mm ²)	(N/mm ²)	(L=4d)%	AT-20°C (J)
Typical Values	550	470	26	60
Spec. Required	490-670	390 min	22 min	27 min

Welding Parameters (DC+VE)

Diameter	Flat		Vertical-Up		Overhead	
	(A)	(V)	(A)	(V)	(A)	(V)
1.2	180-210	26-30	150-210	22-26	180-210	26-30
1.6	210-250	26-30	180-250	21-27	210-250	26-30

Packing : 15 kgs. Vaccum packed plastic spool.

