

## NEXXARC CF-71

AWS-A/SFA5·20E71T-1C

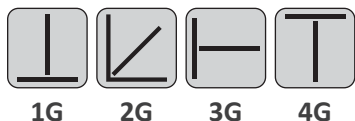
### Applications

**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 CO<sup>2</sup> 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 (CO<sup>2</sup>) 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. (N/mm <sup>2</sup> )	Y.S. (N/mm <sup>2</sup> )	Elongation (L=4d)%	CVN Impact 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	
(mm)	(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. Vacuum packed plastic spool.

