

CHT711

Flux Cored Wire for High Tensile Steels

AWS A5.20 E71T-1C
BS EN ISO 17632 T42 2 P C 1 H10
JIS Z3313 YFW-C50DR
CSA W48-01 E491T-1-H8
GB/T 10045 E501T-1

Type of Flux: Rutile

Welding Position: F, H, HF, OH, V, VD

Type of Current: DCEP

Features & Applications

CHT711 shows excellent welding performance and higher efficiency in welding. Vertical down welding could be applied. It is widely used in structures fabricated by equivalent mild steels and 490MPa grade high tensile strength steels, such as ships, pressure vessels, machineries, petrochemical industry equipments, bridges and so on.

Chemical Composition of Deposited Metal (%)

	C	Mn	Si	S	P
Standard	≤0.18	≤1.75	≤0.90	≤0.03	≤0.03
Typical	0.055	1.35	0.40	0.009	0.018

Mechanical Properties of Deposited Metal (AW)

	Yield Strength ReH (MPa)	Tensile Strength Rm (MPa)	Elongation A4 (%)	Impact Value (J)	Shield Gas
				-20 °C	CO ₂
Standard	≥400	≥480	≥22	≥27	purity≥99.98%
Typical	440	535	32	110	

The standard of mechanical properties conforms to shipping institutions and the certificate of inspection would follow it unless the purchaser has special requirement.

X-ray radiographic inspection: Grade I

Diffusible hydrogen in deposited metal: ≤10ml/100g (mercury process)

Recommended Current (DC⁺)

Diameter(mm)		1.0	1.2	1.4	1.6
Current (A)	F	90-220	120-300	150-380	180-430
	HF	90-200	120-280	150-320	180-380
	V, OH	90-180	120-260	150-270	180-280
	H	90-200	120-280	150-320	180-330
	VD	90-200	200-280	220-300	250-300

Approvals

Institute	CCS	LR	ABS	GL	BV	DNV	NK	BKI	KR	CWB
Grade	3YSMH10	3YS, H10 3YM, H10	3YSAH10	3YH10S	SA3YMH10	III YMS(H10)	KSW53G(C) H10 KAW53MG(C) H10	3YH10S	3YSMG(C1)H10	E491T-9-H8

Notice: 1) The flow rate of shield gas should within 20L-25L/min in welding.

2) The wire extension should be 15mm-25mm.

3) The surfaces to be welded must be cleaned away impurities of oil contamination, rust, moisture and so on.

4) The welding conditions mentioned above for reference only and it is better to do a welding procedure qualification according to project before put it into formal welding.

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