

SC-71Ni2

FLUX CORED ARC WELDING CONSUMABLE
FOR WELDING OF LOW-TEMPERATURE
SERVICE STEEL

2024.12



SC-71Ni2

❖ Specification

<i>AWS A5.29</i>	E71T1-GC
<i>(AWS A5.29M)</i>	E491T1-GC)
<i>EN ISO 17632-A</i>	T 42 6 2Ni P C1 1
<i>JIS Z3313</i>	T49 6 T1-1 C A-N5 H5

❖ Applications

SC-71Ni2 is a titania type flux cored wire for welding of low-temperature service steel.

❖ Characteristics on Usage

SC-71Ni2 is titania type flux cored wire for all position welding with CO₂ shielding gas. This wire provide excellent notch toughness at low temperature down to -60 °C.

※ SC-71Ni2 is designed for only As welded Welding condition, so could not be recommend for PWHT welding.

❖ Note on Usage

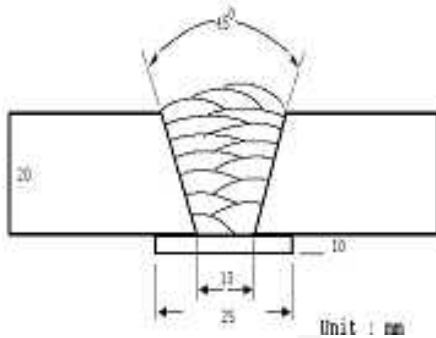
1. For preheating guidelines, please refer to your local standards and codes relative to your best practices
2. Use 100% CO₂ gas
3. Original packaging until ready for use should remain.
4. Remaining after use so that you can be protected from moisture and re-packaging plastic, etc. should be kept in the room and as soon as possible should be used.



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



[Joint Preparation & Layer Details]

Welding Position	: 1G(PA)
Diameter(mm)	: 1.2mm
Shielding Gas	: 100% CO ₂
Flow Rate(ℓ /min.)	: 20
Amp./ Volt.	: 260~280 / 29~31
Stick-Out(mm)	: 20~25
Pre-Heat(°C)	: R.T .
Interpass Temp.(°C)	: 150±15
Polarity	: DC(+)

❖ Mechanical Properties of all weld metal

Consumable	Tensile Test			CVN Impact Test J(ft · lbs)		Remark
	YS MPa (lbs/in ²)	TS MPa (lbs/in ²)	EL(%)	-40°C (-40°F)	-62°C (-80°F)	
SC-71Ni2	510	560	26.5	130	80	As Welded
AWS A5.29 E71T1-GC	≥ 400 (58,000)	490~620 (70,000~ 90,000)	≥ 20	-		

❖ Chemical Analysis of all weld metal(wt%)

Consumable	C	Si	Mn	P	S	Ni
SC-71Ni2	0.04	0.23	1.11	0.010	0.010	2.20
AWS A5.29 E71T1-GC	-	≤1.00	≥0.50	≤0.03	≤0.03	≥0.50

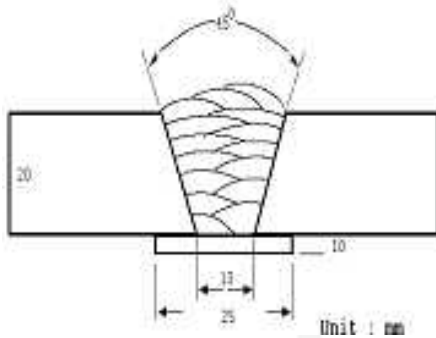
This information is provided solely for the purpose of confirming product conformance with applicable standards. The serviceability of a product or structure utilizing this type of information is and must be the sole responsibility of the builder/user. Many variables beyond the control of HYUNDAI WELDING CO., LTD. affect the results obtained in applying this type of information. These variables include, but are not limited to, welding procedure, shielding gas, plate chemistry and temperature, weldment design, fabrication methods and service requirements.



Mechanical Properties & Chemical Composition of All Weld Metal

❖ Welding Conditions

Method by AWS Spec.



[Joint Preparation & Layer Details]

Welding Position	: 1G(PA)
Diameter(mm)	: 1.4mm
Shielding Gas	: 100% CO ₂
Flow Rate(ℓ /min.)	: 20
Amp./ Volt.	: 290~310 / 29~32
Stick-Out(mm)	: 20~25
Pre-Heat(°C)	: R.T .
Interpass Temp.(°C)	: 150±15
Polarity	: DC(+)

❖ Mechanical Properties of all weld metal

Consumable	Tensile Test			CVN Impact Test J(ft · lbs)		Remark
	YS MPa (lbs/in ²)	TS MPa (lbs/in ²)	EL(%)	-40°C (-40°F)	-62°C (-80°F)	
SC-71Ni2	520	570	26.0	125	75	As Welded
AWS A5.29 E71T1-GC	≥ 400 (58,000)	490~620 (70,000~ 90,000)	≥ 20	-	-	

❖ Chemical Analysis of all weld metal(wt%)

Consumable	C	Si	Mn	P	S	Ni
SC-71Ni2	0.04	0.22	1.10	0.010	0.010	2.20
AWS A5.29 E71T1-GC	-	≤1.00	≥0.50	≤0.03	≤0.03	≥0.50

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Welding Efficiency

❖ Deposition Rate & Efficiency

Consumable (size)	Welding Conditions		Deposition Efficiency(%)	Deposition Rate(kg/hr)
	Amp.(A)	Volt.(V)		
SC-71Ni2 1.2mm	230	27	84~86	2.6
	280	31	84~86	3.6
	330	33	85~87	4.7
SC-71Ni2 1.4mm	250	27	84~86	2.9
	300	31	84~86	3.8
	350	35	85~87	4.9
Remark			Deposition efficiency =(Deposited metal weight/ Wire weight used)×100	Deposition rate =(Deposited metal weight/ Welding time,min.)×60

* Shielding Gas : 100%CO₂



Diffusible Hydrogen Content

❖ Welding Conditions

Diameter(mm)	: 1.2	Amps(A) / Volts(V)	: 230 / 24
Shielding Gas	: 100%CO ₂	Stick-Out(mm)	: 20~25
Flow Rate(ℓ /min.)	: 20	Welding Speed	: 30 cpm
Welding Position	: 1G (PA)	Current Type & Polarity	: DC(+)

❖ Hydrogen Analysis Using Gas Chromatography Method

Hydrogen Evolution Time	: 72 hrs
Evolution Temp.	: 45 °C
Barometric Pressure	: 780 mm-Hg

❖ Result(ml/100g Weld Metal)

X1	X2	X3	X4
4.1	4.2	4.0	4.1

Average Hydrogen Content 4.1 ml / 100g Weld Metal



Proper Welding Condition

❖ Welding Conditions

Consumable	Shielding Gas	Welding Position	Wire Dia. (mm)	
			1.2mm	1.4mm
SC-71Ni2	100% CO ₂	Flat	110~280 Amp	110~280 Amp
		V-up Over head	110~240 Amp	110~260 Amp
		V-down	110~280 Amp	110~280 Amp

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Approvals

❖ AUTHORIZED APPROVAL DETAILS

Welding Position	Register of shipping & Size(mm)				
	ABS	LR	BV	DNV · GL	NK
All V-Down	5YSA H5 1.2~1.4	4YS H5 1.2~1.4	SA5Y HHH 1.2~1.4	6YH5S(H5) 1.2~1.4	KSWL3G(C) H5 1.2~1.4

❖ F No & A No

F No	A No
6	10