Flux Cored Welding Wire

K-70ST

For 490MPa high tensile steel

Classifications

EN ISO 17632-A:2015	: T42 2 R C1 3 H10	AWS A5.20-2005(R2015)	: E70T-9C
EN ISO 17632-B:2015	: T49 3 T1-0C1A H10	AWS A5.36-2016	: E70T1-C1A2-CS1-H8
JIS Z 3313-2009	: T49 2 T1-0CA-U H10	KS D 7104-2012	: YFW-C50DR

Description

- It is designed for welding of 490MPa high tensile steel with outstanding mechanical properties
- It is the most suitable for fillet welding of inorganic zinc-primer coated steels often used in the machineries, steel fabrications and construction industries
- Wire is a titania type of flux cored wire for flat and horizontal position welding
- The arc characteristics are so smooth and stable, even the most novice welder can produce good welds. It has easy slag removal and bigger leg of fillet welding

Welding positions

Polarity & shielding gas

- CO_2: 100% CO_2 (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
CO_2	0.04	0.49	1.36	0.015	0.010

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -20℃	IV (J) -30℃	Remarks
AWS A5.20	min. 390	490~670	min. 22		≥ 27	
EN ISO 17632-B	min. 390	490~670	min. 18		≥ 27	
Example	500	600	27	68	43	CO_2

Notes on usage and welding condition

Dia.(mm)		1.2	1.4	1.6
Current (Amp.)	F (PA/1G)	140 ~ 300	160 ~ 360	180 ~ 420
	HF (PC/2G)	180 ~ 300	180 ~ 350	220 ~ 400

- It will be get to the 7~8mm leg of fillet weld at the welding condition of 340A*34V*30CPM

Package

Dia. (mm)	1.2	1.4	1.6	2.0	2.4
Spool (kg)	5, 12.5, 15, 20			25(Coil)	
Pailpack (kg)	100 ~ 300				

Approvals

ABS, DNV*GL, LR, KR, NK, KS, JIS

* Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.