

Classifications

EN ISO 17632-A:2015	: T46 2 B M21 3 H5	AWS A5.20-2005(R2015)	: E70T-5M
EN ISO 17632-B:2015	: T49 3 T5-0M21A H5	AWS A5.36-2016	: E70T5-M21A2-CS1-H4
JIS Z 3313-2009	: T49 2 T5-0MA-U H5	KS D 7104-2012	: YFW-A502B

Description

- It is designed for welding of 490MPa high tensile steel with only Ar/CO₂ mixtures
- Wire is a fully basic type of flux cored wire for flat and horizontal position welding
- It has good CVN toughness at low temperatures and the weldability is excellent with lower crack susceptibility

Welding positions**Polarity & shielding gas**

- Mix: Ar+20% CO₂ (15~25ℓ/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
Mix	0.04	0.34	1.30	0.015	0.011

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20℃	-30℃	
AWS A5.20	min. 390	490~670	min. 22	≥ 27		
EN ISO 17632-B	min. 390	490~670	min. 18	≥ 27		
Example	490	550	29	80	60	Mix

Notes on usage and welding condition

- Refer to page 219~221 for more information on usage
- Basic type is more generate a fume, so you have to use the ventilation system in small space

Package

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

Approvals

KS, JIS

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