

# KC-70S2

For mild steel and 490MPa tensile strength steel

## Classifications

EN ISO 14341-A:2008	: G 46 2 C G0	AWS A5.18-05	: ER70S-2
	: G 46 2 M G0	JIS Z 3312	: G 49 A 3 C 2
EN ISO 14341-B:2008	: G 49A 3 C G2		
	: G 49A 3 M G2		

## Description

- For butt and fillet welding of ship-building, bridges, structural steel, steel buildings, machineries and vehicles
- Suited for welding of rimmed or semi-killed steel due to containing Al, Ti and Zr as strong deoxidants
- Mainly used for single pass welding, and superior arc stability
- Suited for welding of steels that demand for high impact values on low temperature

## Typical chemical composition of wire (%)

C	Si	Mn	P	S	Ti	Al
0.07	0.67	1.20	0.015	0.011	0.07	0.08

## Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) -30°C	Remarks
AWS A5.18	min. 400	min. 480	min. 22	≥ 27	CO <sub>2</sub>
EN ISO 14341-B	min. 390	490~670	min. 18	≥ 27	CO <sub>2</sub>
Example	490	550	29	80	CO <sub>2</sub>

## Operating data

Dia.(mm)		1.2	1.4
Current (Amp.)	Flat (PA/1G)	100 ~ 350	140 ~ 400
	Vertical (PF/3G)	50 ~ 180	100 ~ 250
	Overhead (PE/4G)	50 ~ 180	100 ~ 250

## Polarity and Shielding gas

- DCEP (DC+)
- CO<sub>2</sub>: 100% CO<sub>2</sub>
- Mix : Ar+20% CO<sub>2</sub> (15~25ℓ /min.)