

## Flux Cored Welding Wire

# K-61T

For 420MPa high tensile steel

### Classifications

EN ISO 17632-B:2015 : T43 Z T1-1M21A  
JIS Z 3313-2009 : T43 0 T1-1MA H10

AWS A5.20-2005(R2015) : E61T-G  
AWS A5.36-2016 : E61T1-M21AY-G  
KS D 7104-2012 : YFW-A430R

### Description

- K-61T is designed for MAG welding of POS-AG steel and low silicon steel for all-position welding applications
- It is applicable to use 400MPa class tensile strength steel welding
- It is controll to lower Si component, so suitable for making zinc primer coated tank
- Wire is a titania type flux cored wire that provides smooth arc, good slag removal and bead shape

### Welding positions



### Polarity & shielding gas

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

### Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
Mix	0.03	0.12	0.80	0.013	0.009

### Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J) 0°C	Remarks
AWS A5.20	min. 330	430~600	min. 22		
EN ISO 17632-B	min. 330	430~600	min. 20		
Example	520	580	29	30	Mix

### Notes on usage and welding condition

- Refer to page 219~221 for more information on usage
- We are recommend under the propriety welding condition, Because it is difficult to V-up welding for high current

### Package

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

### Approvals

JIS, KS

\* Please refer to our homepage([www.kiswel.com](http://www.kiswel.com)) for further detailed information regarding approvals.