

**Classifications**

|                     |                            |                       |                         |
|---------------------|----------------------------|-----------------------|-------------------------|
| EN ISO 17632-A:2015 | : T42 0 R C1 3 H10         | AWS A5.20-2005(R2015) | : E70T-1C/-1M           |
|                     | : T46 0 R M21 3 H10        | AWS A5.36-2016        | : E70T1-C1/M21A0-CS1-H8 |
| EN ISO 17632-B:2015 | : T49 0 T1-0C1(M21)A-U H10 | KS D 7104-2012        | : YFW-C(A)50DM          |
| JIS Z 3313-2009     | : T49J 0 T1-0C/MA-U H10    |                       |                         |

**Description**

- It is designed for welding of 490MPa high tensile steels with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a metal type of flux cored wire for flat and horizontal position welding
- It has better excellent deposition rate and provides smooth arc, low spatter levels

**Welding positions****Polarity & shielding gas**

- CO<sub>2</sub>:100% CO<sub>2</sub>, 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     |
|-----------------|------|------|------|-------|-------|
| CO <sub>2</sub> | 0.03 | 0.50 | 1.45 | 0.014 | 0.010 |

**Typical mechanical properties of all-weld metal**

|                | Y.S<br>(MPa) | T.S<br>(MPa) | El.<br>(%) | IV (J) |      | Remarks         |
|----------------|--------------|--------------|------------|--------|------|-----------------|
|                |              |              |            | 0℃     | -20℃ |                 |
| AWS A5.20      | min. 390     | 490~670      | min. 22    | ≥ 27   | ≥ 27 |                 |
| EN ISO 17632-B | min. 390     | 490~670      | min. 18    | ≥ 47   | ≥ 27 |                 |
| Example        | 520          | 580          | 29         | 70     | 55   | CO <sub>2</sub> |

**Notes on usage and welding condition**

- Refer to page 219~221 for more information on usage
- It is possible to use the 100% CO<sub>2</sub> & mixed gas, but you can get more advantage of welding properties when weld with 100% CO<sub>2</sub> gas.

**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](http://www.kiswel.com)) for further detailed information regarding approvals.