

Classifications

EN ISO 17632-A:2015	: T42 2 P C1 1 H5 : T46 2 P M21 1 H10	AWS A5.20-2005(R2015)	: E71T-1C/-1M AWS A5.36-2016	: E71T1-C1A0- CS1-H4 : E71T1-M21A0- CS1-H8
EN ISO 17632-B:2015	: T49 2 T1-1C1A-U H5 : T49 2 T1-1M21A-U H10	KS D 7104-2012		: YFW-C(A)50DR
JIS Z 3313-2009	: T49 2 T1-1C/M A-U H10			

Description

- It is designed for welding of 490MPa high tensile steel with outstanding mechanical properties
- Typical applications include machineries, shipbuilding, offshore structures, bridges and general fabrications
- Wire is a titania type of flux cored wire for all-position welding general fabrications
- It provides low fume generation and has good impact strength at low temperatures
- It also provides excellent usability with stable arc, less spatter levels, smooth bead shape

Welding positions



Polarity & shielding gas

- CO₂: 100% CO₂
- Mix: Ar+20% CO₂ (15~25l/min)
- DCEP (DC+)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S
CO ₂	0.03	0.38	1.35	0.015	0.010

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	IV (J)		Remarks
				-20°C	-30°C	
AWS A5.20	min. 390	490~670	min. 22	≥ 27		
EN ISO 17632-B	min. 390	490~670	min. 18	≥ 47		
Example	520	570	28	80	50	CO ₂

Notes on usage and welding condition

- Refer to page 219~221 for more information on usage
- When heat input is excessive, the impact value tends to be reduced. Therefore, perform welding with selecting proper heat input
- When you use to Ar+CO₂ mixture gas, you should be lower 1~2 voltage than 100% CO₂ gas

Package

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

Approvals

ABS, BV, DNV*GL, LR, NK, KR, RINA, RS, CCS, CWB, JIS, TUV, DB

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