

## Flux Cored Welding Wire

# K-NGS11

For 490MPa high tensile steel (Self-Shielded, multi pass)

### Classifications

EN ISO 17632-A:2016 : T42 Z Y NO 1	AWS A5.20-2005 : E71T-11
EN ISO 17632-B:2016 : T49 Z T11-1NOA	AWS A5.36-2016 : E71T11-AZ-CS3
JIS Z 3313-2009 : T49 T7-1 N A	KS D 7104 -2012 : YFW-S50GB

### Description

- It is designed for welding of 490MPa high tensile steel and self-shielded wire to facilitate welding outdoors
- Typical applications include general fabrication and structural work requiring no impact properties (ASTM A36 Gr. All; A109 Gr. All; A283 Gr. A,B,C,D; A284 C,D; A285 Gr. A,B,C; A288 Gr. 1; A372 type I ; A500 Gr. All; A501 Gr. all)
- It has good arc stability, low spatter generation, high efficiency, good bead shape and slag removal
- It has to use DCEN (electrode negative)

### Welding positions



### Polarity & shielding gas

- DCEN (DC-)

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

Shielding gas	C	Si	Mn	P	S	Al
	0.10	0.10	0.55	0.015	0.006	1.21

### Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.20	min. 390	490-670	min. 20	
EN ISO 17632-B	min. 390	490-670	min. 18	
Example	500	530	23	

### Notes on usage and welding condition

Dia.(mm)	0.9	1.2	1.6
Current F (PA/1G)	80 ~ 120	120 ~ 180	240 ~ 280
(Amp.) HF (PC/2G)	(18 ~22)	(21 ~23)	(22 ~24)
VU (PF/3G)	100 ~ 160(22 ~25)		

- Self-shielded FCW is to more generate a fume than titania type FCW So you have to use the ventilation system in small space

### Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15, 20		
Coil (kg)			20, 25

### Approvals

JIS, KS

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