

Flux Cored Wire for High Tensile Strength Steel

KFX-70T

Classification

AWS	A5.20	E70T-1C
JIS	Z3313	T49J0T1-0CA-U
EN	7632-A	T 42 2 R 3
GB	T 10045	E500T-1

Shielding Gas: CO₂

Applications and Features

- (1) KFX-70T is designed for welding 490N/mm² grade steel with CO₂ gas.
- (2) It is used for single or multi-pass welding of mild steel.
- (3) It provides: low spatters, good weldability, deeper penetration in fillet welding and superior X-ray quality welds.
- (4) It is widely used for the multi-pass welding in ship-building, tanks, industrial machines, steel structures and bridges.

Welding position

F(1G) , H-Fillet (2F)

Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.080	0.53	1.30	0.020	0.013

Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm ² (kgf/mm ²)	Yield Strength N/mm ² (kgf/mm ²)	Elongation %	Charpy V-Notch °C	J (kgf -m)
560(57.1)	470(47.9)	27	-18	—
			-20	58(5.9)

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6
Amp			
F	120~300	150~400	180~450
H-fillet	120~300	150~350	180~400