

Flux Cored Wire for High Tensile Strength Steel

KFX-719

Classification

AWS	A5.20	E71T-9C
JIS	Z3313	T493T1-1CA
EN	17632-A	—
GB	T 10045	E501T-9

Shielding Gas: CO₂

Applications and Features

- (1) KFX-719 is suitable for welding 490N/mm² grade steel.
- (2) It has superior impact properties at low temperature.
- (3) It is ideal for welding in ship-building, bridges, steel structures and constructions.

Welding Position

All Positions

Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.045	0.35	1.51	0.015	0.011

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)
590 (602)	540 (55.1)	23	-29	107(13.0)
			-40	75(11.7)

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
	V-up	120~200	150~320	180~240
	H	120~280	150~320	180~350
	V-down	200~260	220~270	230~280