

# Flux Cored Wire for Low Alloy Steel

## KFX-81TW2

### Classification

AWS	A5.29/A5.29M	E81T-W2
JIS	Z3310	T553T1-1CA-NCC1
EN		
GB		

Shielding Gas      CO<sub>2</sub>

### Applications and Features

- (1) It is suitable for butt or fillet MAG welding of 590N/mm<sup>2</sup> grade steel with 100% CO<sub>2</sub> gas.
- (2) It is a titania type flux cored wire applicable for al-position welding.
- (3) It has good bead appearance, smooth bead shape and low spatter.
- (4) It is ideal for welding A588 and A242 (which are normally used without painting).

### Welding Position

All Positions

### Welding Instruction

- (1) Preheat Temp.: 100±10°C, Interpass Temp.: 150±15°C (Note : Usually no post weld heat treatment needed.)

### Typical Chemical Composition of Weld Metal (wt %)

C	Si	Mn	P	S	Cr	Ni	Mo
0.06	0.45	0.77	0.02	0.012	0.55	0.51	0.42

### Typical Mechanical Properties of Weld Metal

Tensile Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Yield Strength N/mm <sup>2</sup> (kgf/mm <sup>2</sup> )	Elongation %	Charpy V-Notch	
			°C	J (kgf -m)
588(60)	530(54)	24	-20	--
			-29	45
			-40	--

### 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