

Metal Cored Wire for High Tensile Strength Steel

KMX-70C

Classification

AWS	A5.18/ A5.08M	E70C-6
JIS	Z3313	T493T6-0NA
EN	17632-A	T423MM3
GB	T 10045	E500T-G

Shielding Gas: CO₂

Applications and Features

- (1) KMX-70C is a metal wire designed for welding 490N/mm² grade steel.
- (2) Compared with flux cored wire (e.g. E71T-1), KMX-70C has higher deposition rate, faster travel speed, superior arc wetting and better bead appearance.
- (3) This wire generates less silicon island on the bead surface, which makes it a preferable choice over solid wire.
- (4) It is ideal for welding in steel structure buildings, bridges and other middle to thick plate welding applications.

Welding Position

Flat, H-Fillet

Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt. %)

C	Si	Mn	P	S
0.050	0.62	1.55	0.016	0.008

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)
540 (55.1)	450 (45.9)	26	-29	45(4.6)

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.4	1.6	2.0	
Amp	F	200~350	250~450	250~550	350~650
	H-Fillet	200~320	220~450	250~550	350~600