

Flux Cored Wire for High Tensile Strength Steel

KFX-70T

| Classification | |
|------------------|------------------|
| AWS A5.20/A5.20M | E70T-1C/E490T-1C |
| JIS Z3213 | T49J0T1-0CA-U |
| EN ISO 17632-A | T42 2 R C1 3 H10 |
| GB T10045 | E500T-1 |

Shielding Gas:100% CO₂

Applications and Features

- (1) KFX-70T is suitable for welding 490N/mm² grade steel with flat and horizontal position.
- (2) High-deposition-rate of multi-layer fillet welding in horizontal and flat position.
- (3) High resistance against porosity when welded on primer-coated steel plates.
- (4) Uniform slag covering, regular weld toes, glossy bead surface and smooth lapping onto the preceding bead in multi-layer fillet welding.
- (5) Ideal for ship-building, tanks, bridges, steel structures and constructions.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.06 | 0.60 | 1.36 | 0.018 | 0.005 |

Typical Mechanical Properties of Weld Metal

| Tensile Strength | Yield Strength | Elongation | Charpy V-Notch | |
|-------------------|-------------------|------------|----------------|-----|
| N/mm ² | N/mm ² | % | °C | J |
| 567 | 407 | 27 | 0 | 102 |
| | | | -20 | 81 |

Size and Suggested Operating Range (DC+)

| Diameter (mm) | 1.2 | 1.4 | 1.6 |
|---------------|-----------------|-----------------|-----------------|
| F/HF | 160~300A/24~36V | 200~350A/26~34V | 270~400A/28~40V |