

Self-Shielding Flux Cored Wire for High Tensile Strength Steel

KFX-70GS

Classification

AWS A5.20/A5.20M	E70T-GS/E490T-GS
JIS Z3213	T49ZT4-0NA
EN ISO 17632-A	T42 Z Y N 3
GB T10045	T 49 TG-1 N S

Shielding Gas: Non

Applications and Features

- (1) KFX-70GS is suitable for welding 490N/mm² grade steel without shielding gas.
- (2) Stable arc, good slag removal and good bead appearance.
- (3) Ideal for repairing agricultural implements, machinery and light steel structure.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Al
0.17	0.05	0.77	0.028	0.005	0.12

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
613	475	20	-	-

Size and Suggested Operating Range (DC+)

Diameter (mm)	0.8	0.9	1.2	1.6
F/HF	100~150A/17~19V	100~160A/17~20V	140~250A/18~24V	160~280/18~26V