

Flux Cored Wire for High Tensile Strength Steel

KFX-715

Shielding Gas:100%CO₂

Classification

AWS A 5.20/A5.20M	E71T-5C/E491T-5C
JIS Z3313	T494T5-1CA-U
EN ISO 17632-A	T42 4 B C1 1 H5
GB T10045	T49 4 T5-1 C1 H5

Applications and Features

- (1) KFX-715 is suitable for welding 490N/mm² grade steel.
- (2) Low hydrogen, excellent crack resistance and impact toughness at low temperature.
- (3) Ideal for welding ship-building, steel structure and machinery.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.05	0.37	1.61	0.022	0.010

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch	
N/mm ²	N/mm ²	%	°C	J
559	506	28	-40	81

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2	1.6
F/HF	130~300A/24~36V	160~340A/24~38V
H	130~280A/22~33V	160~280A/24~34V
V-up/OH	130~220A/22~28V	160~280A/22~28V
V-down	230~280A/28~33V	250~320A/28~32V