

## 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	T 49 2 T1-0 C1 A

Shielding Gas:100% CO<sub>2</sub>

### Applications and Features

- (1) KFX-70T is suitable for welding 490N/mm<sup>2</sup> 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 <sup>2</sup>	N/mm <sup>2</sup>	%	°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