

Flux Cored Wire for High Tensile Strength Steel

KFX-712C

Classification

AWS A 5.20/A5.20M	E71T-12C/E491T-12C
JIS Z3313	T494T1-1CAP-U H10
EN ISO 17632-A	T42 4 P C1 1 H10
GB T10045	T49 4 T12-1 C1 A

Shielding Gas:100% CO₂

Applications and Features

- (1) KFX-712C is suitable for all-position welding of 490N/mm² grade steel
- (2) Excellent impact toughness at low temperature after PWHT.
- (3) Ideal for welding shipbuilding, tank, construction machine, pressure vessel, steel structure and bridge.

Welding position



Welding Instruction

Please refer to Appendix D.

Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S
0.08	0.43	1.43	0.017	0.008

Typical Mechanical Properties of Weld Metal

Tensile Strength	Yield Strength	Elongation	Charpy V-Notch		Heat Treatment
N/mm ²	N/mm ²	%	°C	J	
596	555	27	-40	47	As-welded
573	494	29	-40	48	620°C × 6hr

Size and Suggested Operating Range (DC+)

Diameter (mm)	1.2
F/HF	140~300A/23~36V
H	140~280A/22~33V
V-up/OH	140~220A/22~28V
V-down	230~280A/28~33V