

## Flux Cored Wire for High Tensile Strength Steel

# KFX-719J

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

### Classification

AWS A 5.20/A 5.20M

JIS Z3313

EN ISO 17632-A

GB T10045

E71T-9C-J H4/E491T-9C-J H4

T494T1-1CA

T42 4 P C 1 1 H5

T49 4 T1-1 C 1 A H5

### Applications and Features

- ( 1 ) KFX-719J is suitable for 490N/mm<sup>2</sup> grade steel.
- ( 2 ) Less fume, stable arc, good slag removal and good bead appearance.
- ( 3 ) Ni content in weld metal provides excellent impact toughness at low-temperature.
- ( 4 ) Ideal for welding steel structure, shipbuilding, offshore structure, and foundation of offshore wind mill.

### Welding position



### Welding Instruction

Please refer to Appendix D.

### Typical Chemical Composition of Weld Metal (wt%)

C	Si	Mn	P	S	Ni
0.04	0.35	1.51	0.015	0.011	0.31

### 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
590	540	27	-40	95

### 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