

Classifications

EN ISO 17632-A:2016 : T42 Z V NO 1
 EN ISO 17632-B:2016 : T49 Z TG-1NOS
 JIS Z 3313-2009 : T49 TG-1 N S

AWS A5.20-2005 : E71T-GS
 AWS A5.36-2016 : E71T14S-AZ-CS3
 KS D 7104 -2012 : YFW-S50GB

Description

- It is designed for welding of 490MPa high tensile steel and self-shielded wire to facilitate welding outdoors
- Typical applications include general fabrication and structural work requiring no impact properties (ASTM A36 Gr. All; A109 Gr. All; A283 Gr. A,B,C,D; A284 C,D; A285 Gr. A,B,C; A288 Gr. 1; A372 type I ; A500 Gr. All; A501 Gr. all)
- It has good arc stability, low spatter generation, high efficiency, good bead shape and slag removal
- It has to use DCEN (electrode negative)

Welding positions**Polarity & shielding gas**

- DCEN (DC-)

Typical chemical composition of all-weld metal (%)

Shielding gas	C	Si	Mn	P	S	Al
	0.10	0.10	0.55	0.014	0.006	1.21

Typical mechanical properties of all-weld metal

	Y.S (MPa)	T.S (MPa)	El. (%)	Remarks
AWS A5.20		min. 490		
EN ISO 17632-B	min. 390	490~670	min. 18	
Example	489	520	22	

Notes on usage and welding condition

Dia.(mm)	0.9	1.2	1.6
Current F (PA/1G)	80 ~ 120	120 ~ 180	240 ~ 280
(Amp.) HF (PC/2G)	(18 ~22)	(21 ~23)	(22 ~24)
VU (PF/3G)	100 ~ 160(22 ~25)		

Package

Dia. (mm)	0.9	1.2	1.6
Spool (kg)	5, 12.5, 15, 20		
Coil (kg)			20, 25

- Self-shielded FCW is to more generate a fume than titania type FCW So you have to use the ventilation system in small space

Approvals

CWB, JIS, KS

- Please refer to our homepage(www.kiswel.com) for further detailed information regarding approvals.