

For Mild Steel and 490MPa High Tensile Strength Steel

APPLICATIONS

Welding of mild steel and 490MPa high tensile strength steel for automobiles, rolling stock, machinery, air conditioners, tools light gauge steel, steel frames, bridges and ships.

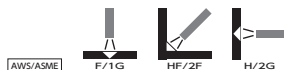
CHARACTERISTICS

YM-26 is a gas metal arc welding wire to be used with CO₂ shield gas. Arc is stable, spatters are few and weldability is excellent even in high welding current range. High efficiency is obtained since deposition rate is high and penetration is deep.

GUIDELINES FOR USAGE

1. Applicable welding position: flat position, horizontal fillet and horizontal position.
2. Heat input: MAX 30kJ/cm and Interpass temperature: MAX 250°C for 490MPa steel.
3. Suitable wire extension (between contact tip and base metal): 20-30mm.

WELDING POSITION



■ TYPICAL CHEMICAL COMPOSITION OF WELD METAL (%)

Shield Gas	C	Si	Mn	P	S	Ti
CO ₂	0.07	0.52	1.11	0.017	0.011	0.04

■ TYPICAL MECHANICAL PROPERTIES OF WELD METAL

PWHT	Yield Strength, MPa	Tensile Strength, MPa	Elongation, %	Charpy 2V-notch at 0°C, J
As-welded	460	560	28	130
625°C×3hr	400	510	31	180

■ SIZES & RECOMMENDED CURRENT RANGE<DC(+)>

Diameter (mm)	1.0	1.2	1.4	1.6	2.0
Current A	F	70~250	100~350	150~470	200~550
	H	70~250	100~350	150~450	200~450
	H-Fil	70~250	130~300	150~400	200~450