

KSF-70

Self-Shielded Flux Cored Wire for High Strength Steel

Classifications:

GB/T10445 E500T-7
 AWS A5.20 E70T-7
 A5.20M E490T-7
 EN 758 T 42 Z W N3
 ISO 17632 B-T49ZT7-0NA-G

Characteristics and Applications:

It is a kind of self-shielded flux cored wire for high strength steel with DC-, it exhibits good penetration, good moisture index, fast deposited rate. Excellent X-ray and sulfur removal, and crack in heavy plate, stress joint and medium carbon steel can be reduced. It has good operation and slag removal and good appearance. It is suitable for the welding of heavy plate and 490Mpa high tensile steel.

Welding Position: 

Typical Chemical Composition of All-Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V	AC
AWS	0.30	1.75	0.60	0.20	0.50	0.30	0.03	0.03	0.08	1.8
Tested	0.026	0.46	0.15	0.022	0.010	0.007	0.014	0.008	0.004	1.35

Mechanical Properties of All-Weld Metal:

Mechanical Properties	Yield Stress (Mpa)	Tensile Strength (Mpa)	Elongation %	Impact values J/°C
AWS	390	490-670	22	-
Tested	435	605	27	-

Notes on Usage:

1. Polarity: DC-.
2. Turn up the volt to 1-2V when electric cable is more than 15m.
3. The interpass temperature should be kept around 150°C for multilayer welding.
4. If low temperature impact is required, it is not recommended.

Sizes Available and Recommended Parameter:

Dia/mm	1.6	2.0	2.4	2.8
Volt	22-30	24-32	26-34	28-38
Amp	160-300	200-350	250-400	280-450
Stick-out(mm)	40-60	40-60	40-60	40-60