



# KF-702

Special Designed for ElectroGas Welding  
Flux Cored Wire for High Strength Steel

## Classifications:

GB-  
AWS A5.26 EG70T-2  
A5.26M EG482T-2

## Characteristics and Applications:

It is used in vertical welding of ship hull and cargo warehouse and butt welding of various inner structure, side board of tank. It exhibits stable arc and good weld appearance when it is shielded by CO<sub>2</sub> and small diameter electrogas welding with high melting rate flux cored wire. Vertical welding can be easily done if SEGARC is used.

Welding Position: 

## Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S
AWS	-	2.00	0.90	0.20	0.30	0.35	0.03	0.03
Tested	0.08	1.63	0.35	-	0.02	0.17	0.014	0.010

## Typical Mechanical Properties of Weld Metal:

Mechanical Property	Yield Stress (MPa)	Tensile Strength . S. (MPa)	Elongation ( % )	Impact values (J/°C)
AWS	350	480-650	22	27J /-2 0°C
Tested	470	600	25	62J /-2 0°C

## Notes on Usage:

- 1.Polarity : DC+
- 2.Moisture,rust,oil in parent metal should be fully removed before welding.
- 3.Anti-wind measures should be used when wind speed is more than 2m/s,where porosity easily happens.
- 4.Use over 99.98%purity of CO<sub>2</sub> as shielding gas.This product cannot use mixed gas.
- 5.The length of stick-out should be controlled as 35-40mm.

## Sizes Available and Recommended Parameters:

Diameter/mm	1.6	2.0	2.4
F	24-32	26-32	28-48
OH	200-350	260-450	350-600
Electric current range (Amp)			
VU	15-20	20-25	25-30
VD	15-25	20-25	20-25

**ecoweld**<sup>®</sup>

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