

# KFM70 6M

METAL -CORED WIRE FOR HIGH TENSILE STEEL 490Mpa Grade

## Classifications:


AWS A5.18 E70C-6M  
 A5.18M E48C-6M  
 EN ISO 17632-A:T 42 3 M M21 1  
 EN ISO 17632 B:T49 3T15-1M21A

## Application

1. Suitable for automated or semi - automated welding in X70 pipe, manufacturing machinery, structure, pipeline, automobiles and etc. mostly used in the root of pipe welding.

## Characteristics

1. Soft and stable arc , few spatter, beautiful weld bead appearance ,almost no slag , few smoke and with excellent weldability.
2. Excellent low temperature impact toughness and crack resistance.

Welding Position:  Polarity : DC+

## Typical Chemical Composition of Weld Metal:

Alloy wt%	C	Mn	Si	Cr	Ni	Mo	P	S	V
AWS	0.12	1.75	0.90	0.20	0.50	0.30	0.03	0.03	0.08
KFM70 6M	0.030	1.54	0.50	0.02	0.01	0.01	0.010	0.005	0.01

## Typical Mechanical Properties of Weld Metal:

Mechanical Property	Y.S. (MPa)	T.S. (MPa)	EI ( % )	CVN(J/°C)
AWS	400	480	22	27J /-3 0°C
KFM70 6M	445	550	28	100J /-3 0°C

## Notes on Usage:

1. Shielding gas :75-80%Ar+CO<sub>2</sub>;
2. Preheat and interpass temperature : 150±15°C;
3. Welding Machine mode set on solid wire.
4. Set up wind protection when welding in windy surroundings to prevent blowholes.

## Sizes Available and Recommended Parameters:

Diameter/mm	1.0	1.2
Volt	15-30	16-34
Amp	110-250	120-300
Stick-Out(mm)	15-20	15-20
Gas Flow(l/min)	15-25	15-25